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Data Base Documentation Book for 00-ALC/MANPRA Book 2 of 5

Contract

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**TECHNOLOGY INSERTION-ENGINEERING SERVICES  
PROCESS CHARACTERIZATION  
TASK ORDER NO. 1**

**BOOK 2 OF 5**

**DATABASE DOCUMENTATION BOOK**

**OO-ALC**

**MANPRA**

**(C5 MAIN LANDING GEAR - WCD'S)**

**CONTRACT SUMMARY REPORT  
15 DECEMBER 1989**

**CONTRACT NO. F33600-88-D-0567  
CDRL SEQUENCE NO. B008**

**MCDONNELL DOUGLAS**

**McDonnell Douglas Missile Systems Company  
St. Louis, Missouri 63166-0516 (314) 232-0232**

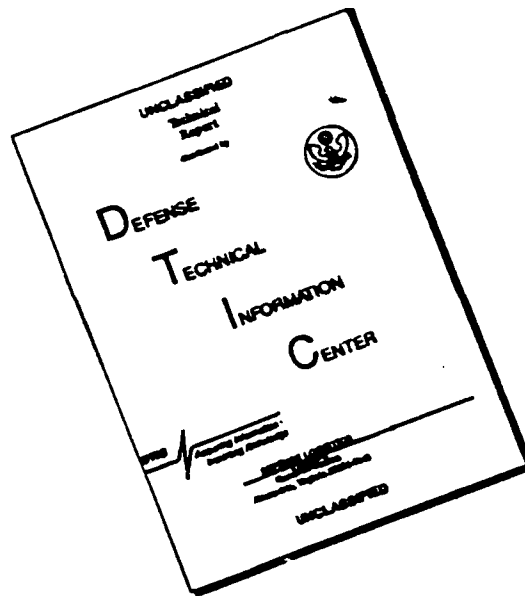
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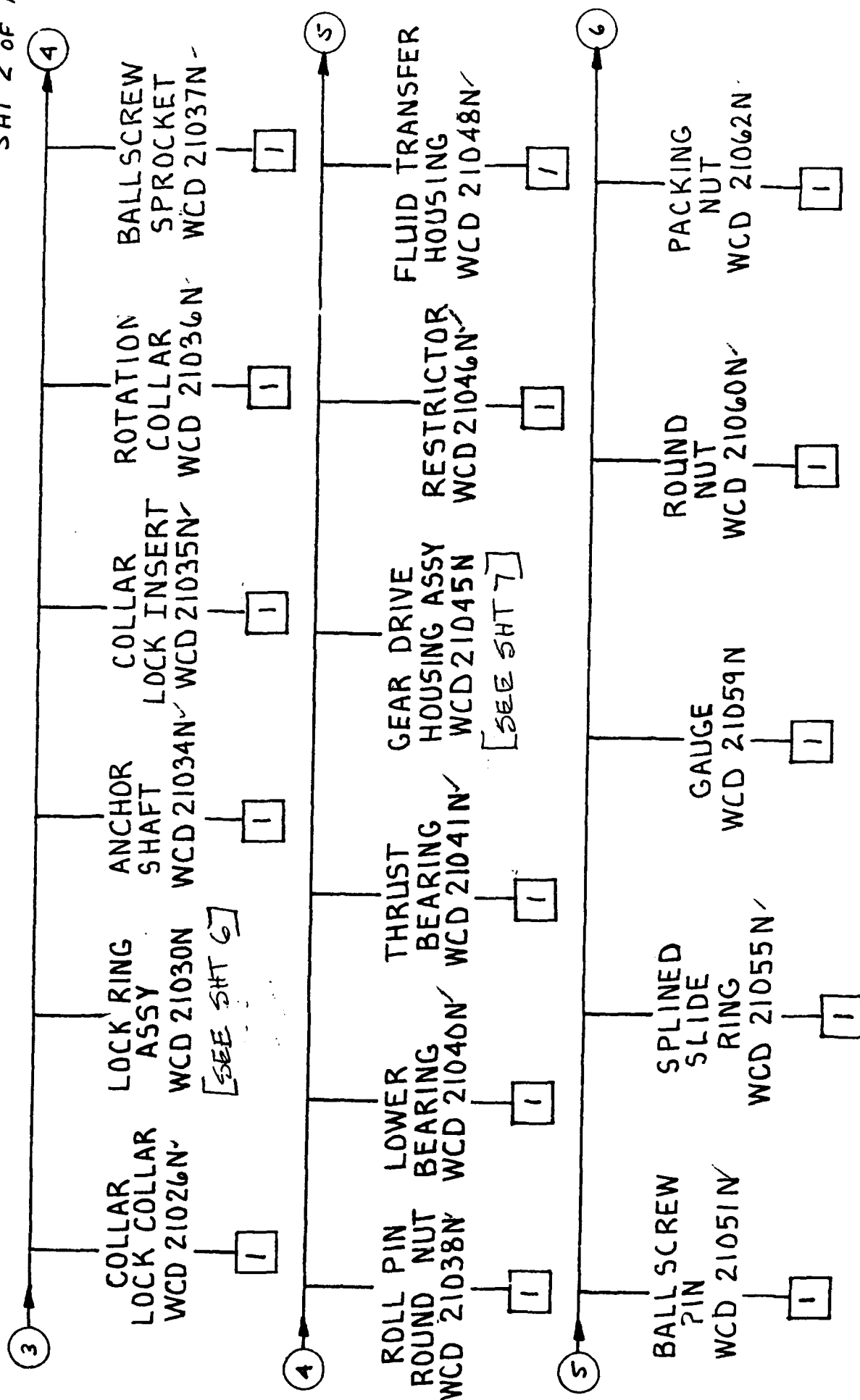
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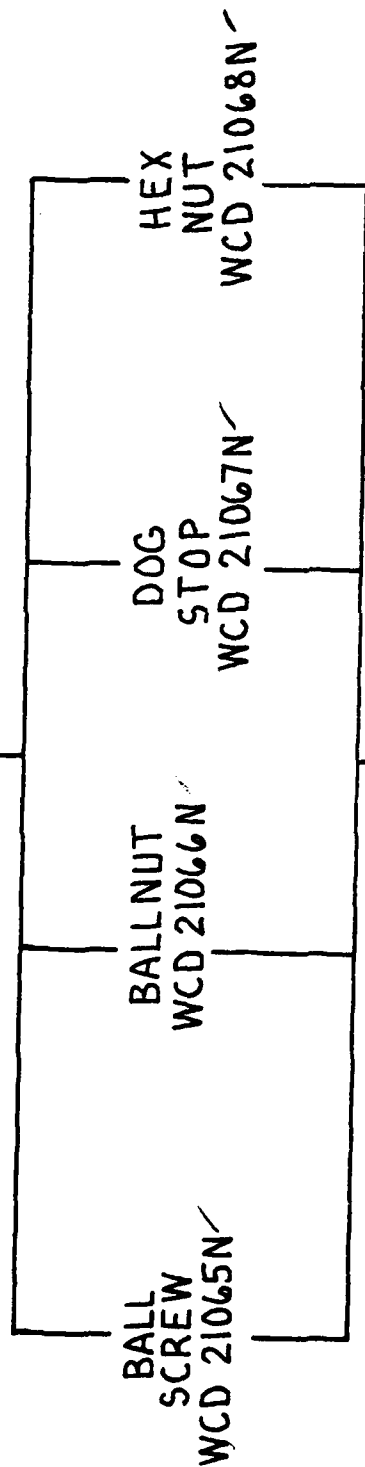




6

7

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WCD 21069N  
"PCN 74652A"



BALL SCREW DISASSEMBLY  
WCD 21098N  
"PCN 74652A"

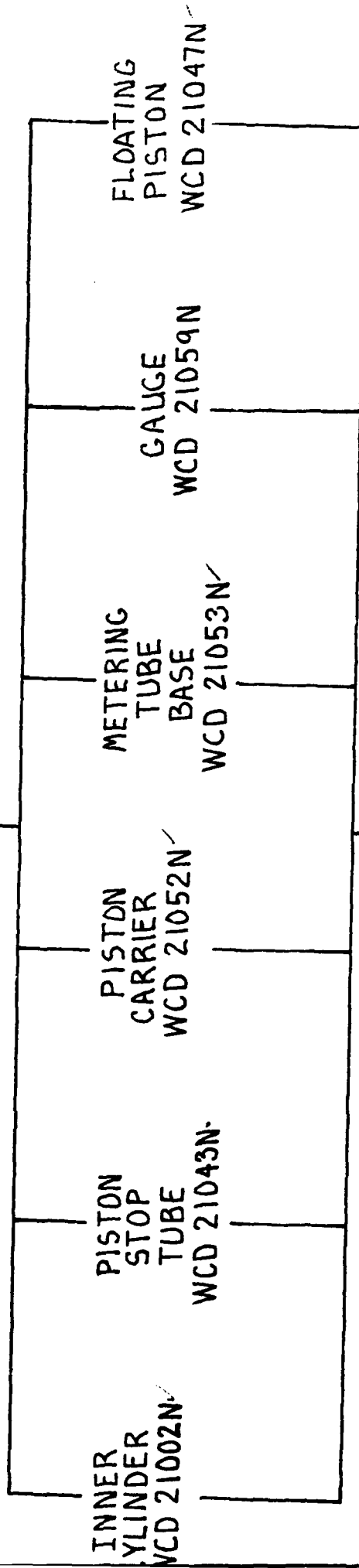
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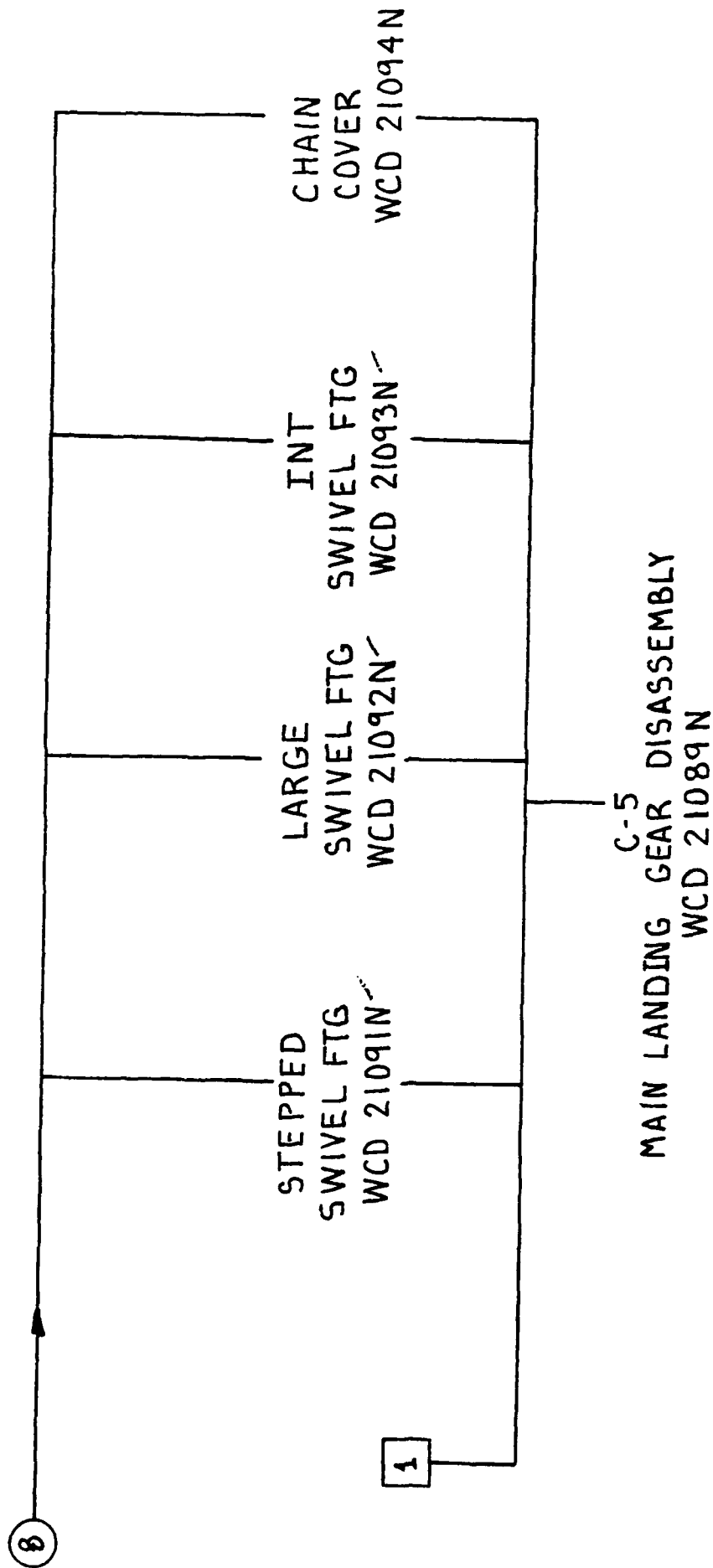
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7

8

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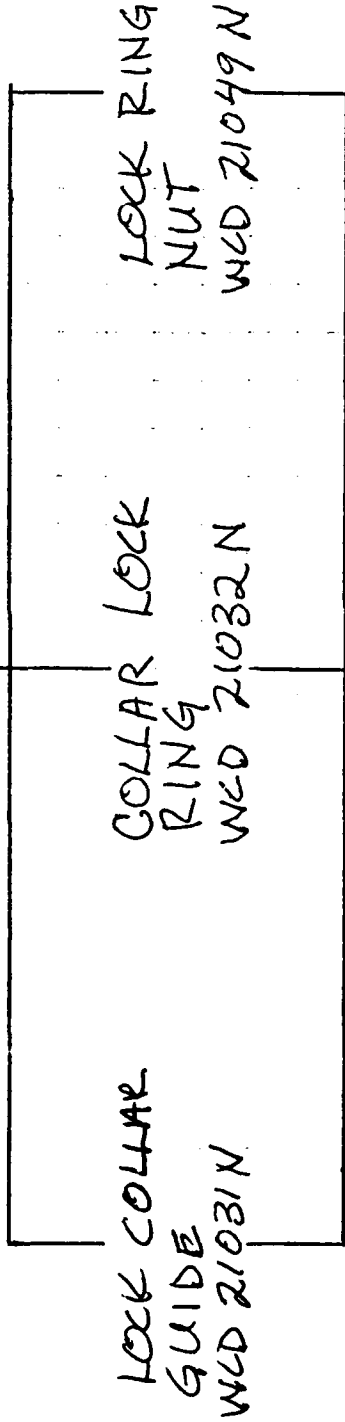




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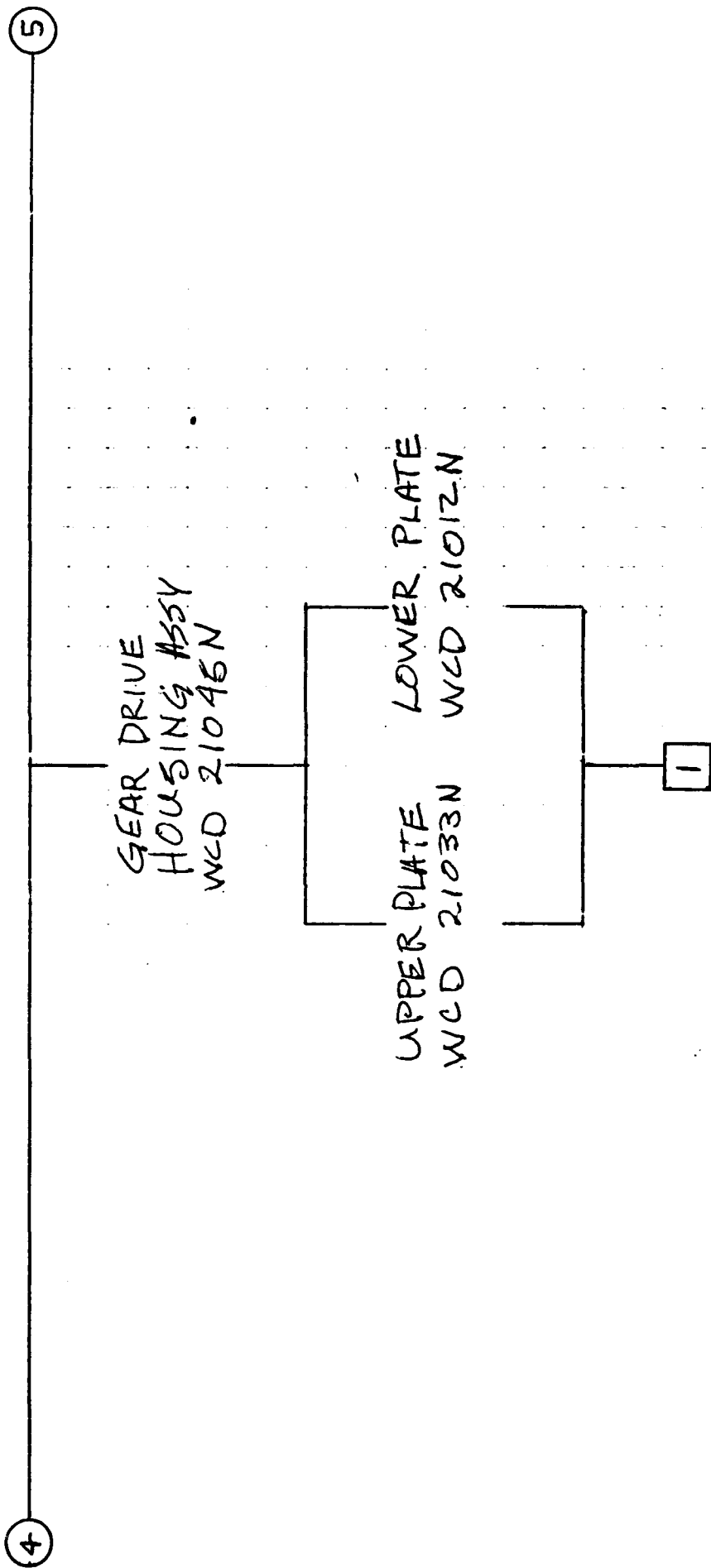


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ASSY  
WCD 21030N



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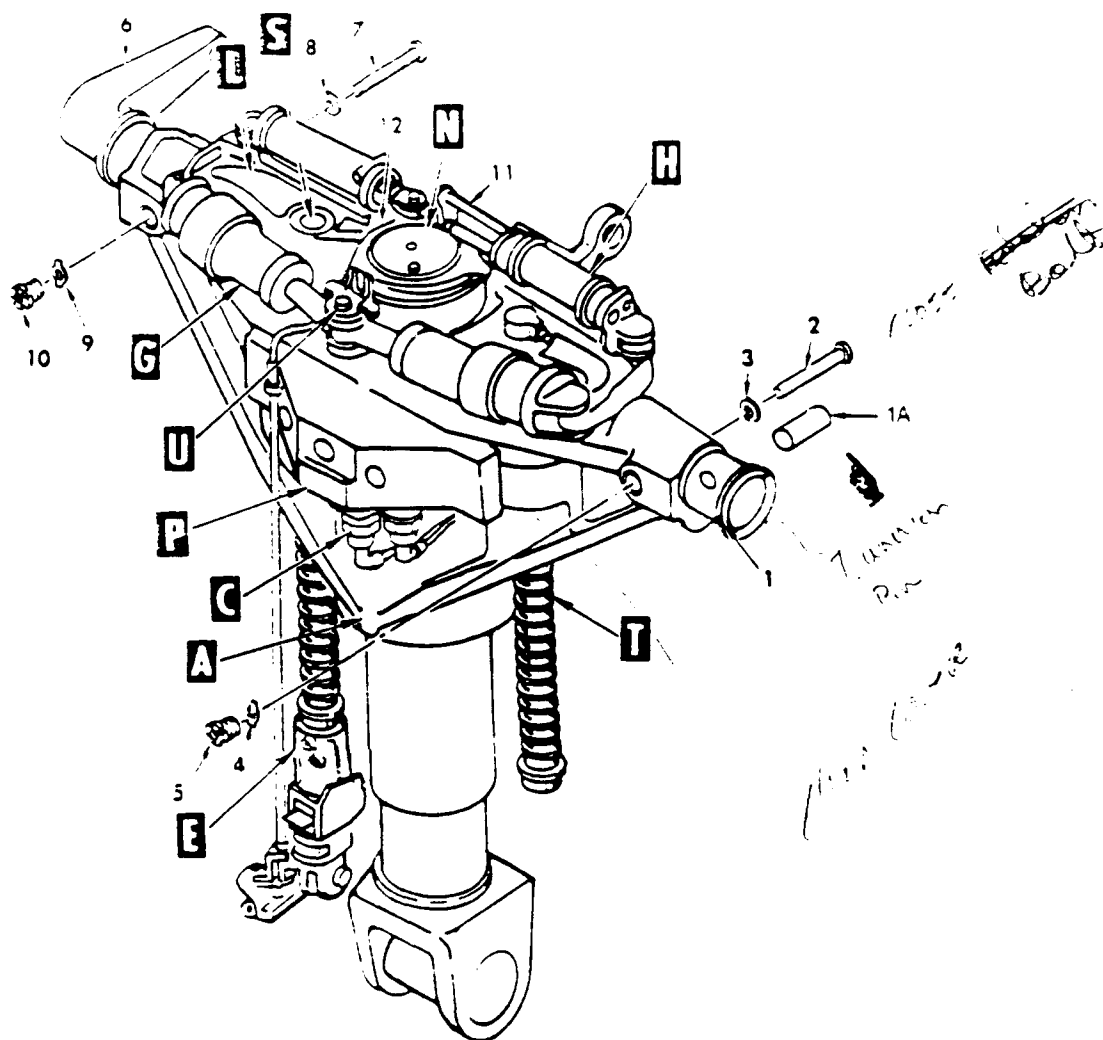
SH 7 of 7



DBB\*8

C517L6 Break

C-5A MLG



R

Figure 2-8. RH Att Strut Assembly (Sheet 1 of 18)

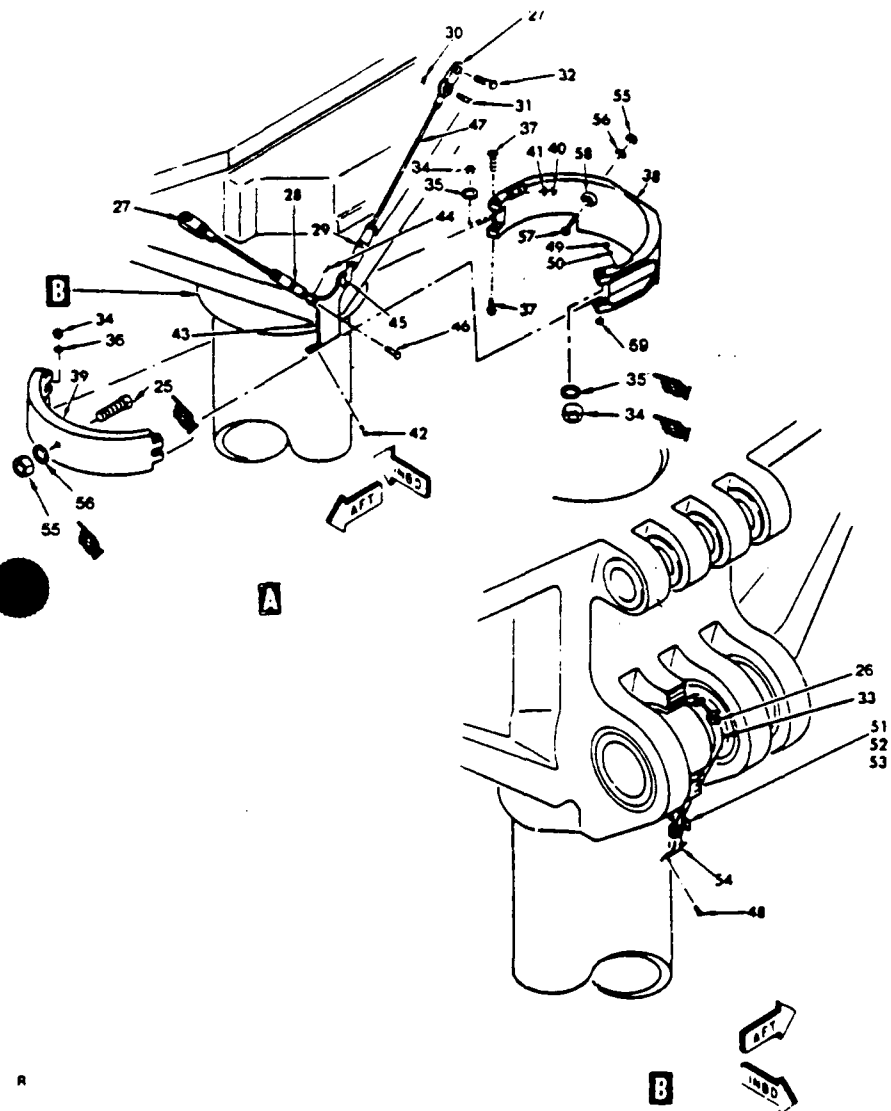


Figure 2-8. RH Aft Strut Assembly (Sheet 2 of 18)



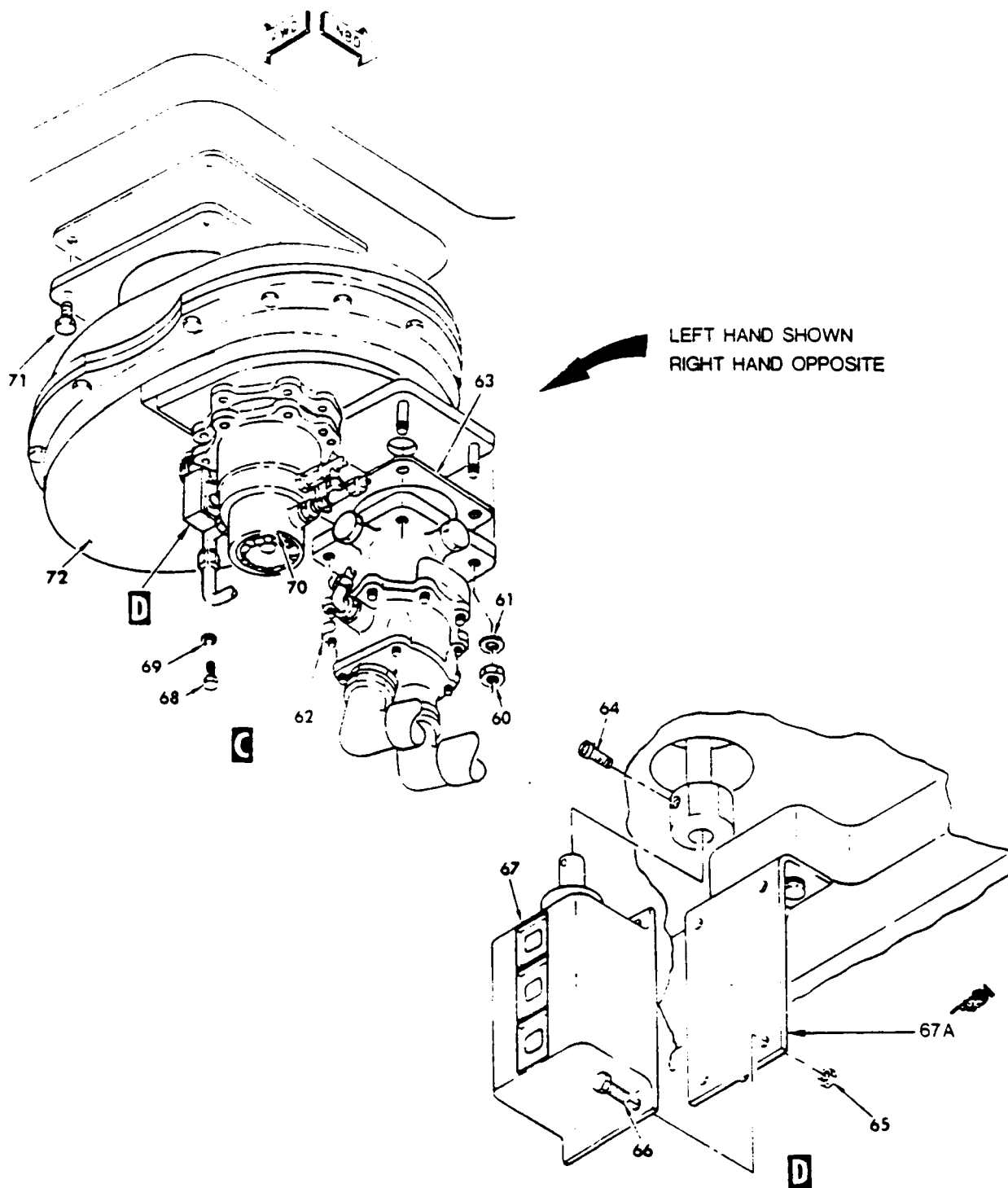


Figure 2-8. RH Aft Strut Assembly (Sheet 3 of 18)

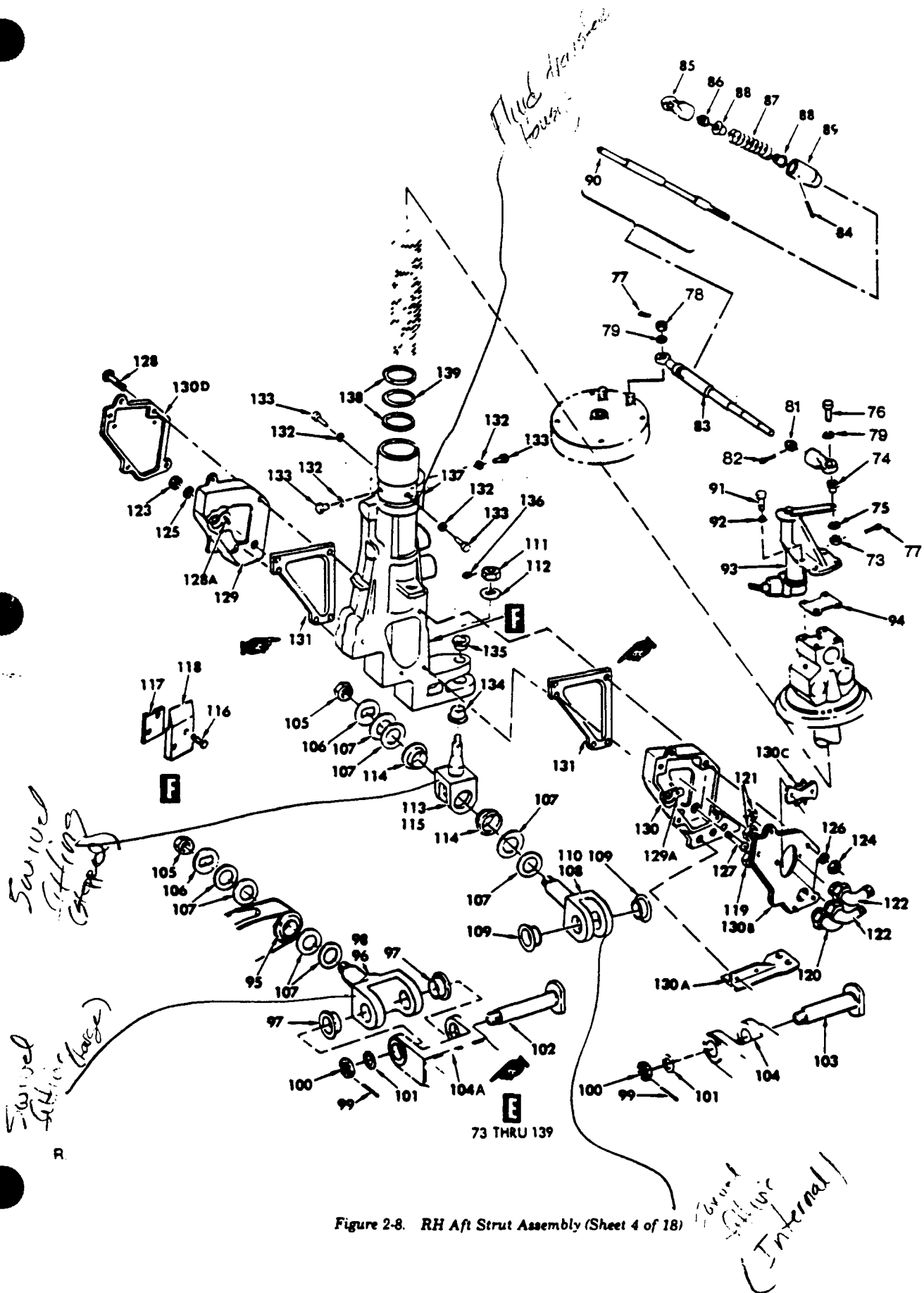


Figure 2-8. RH Aft Strut Assembly (Sheet 4 of 18)

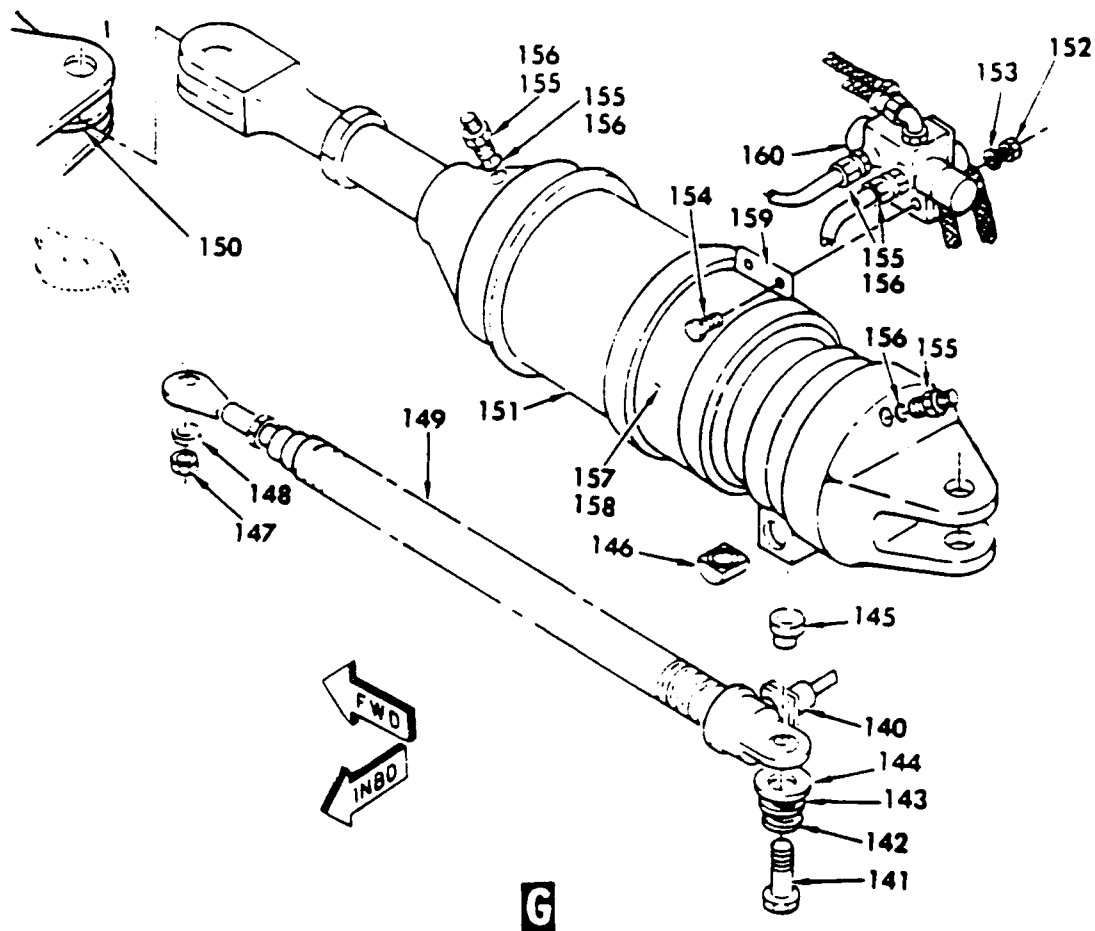


Figure 2-3. RH Aft Strut Assembly (Sheet 5 of 18)

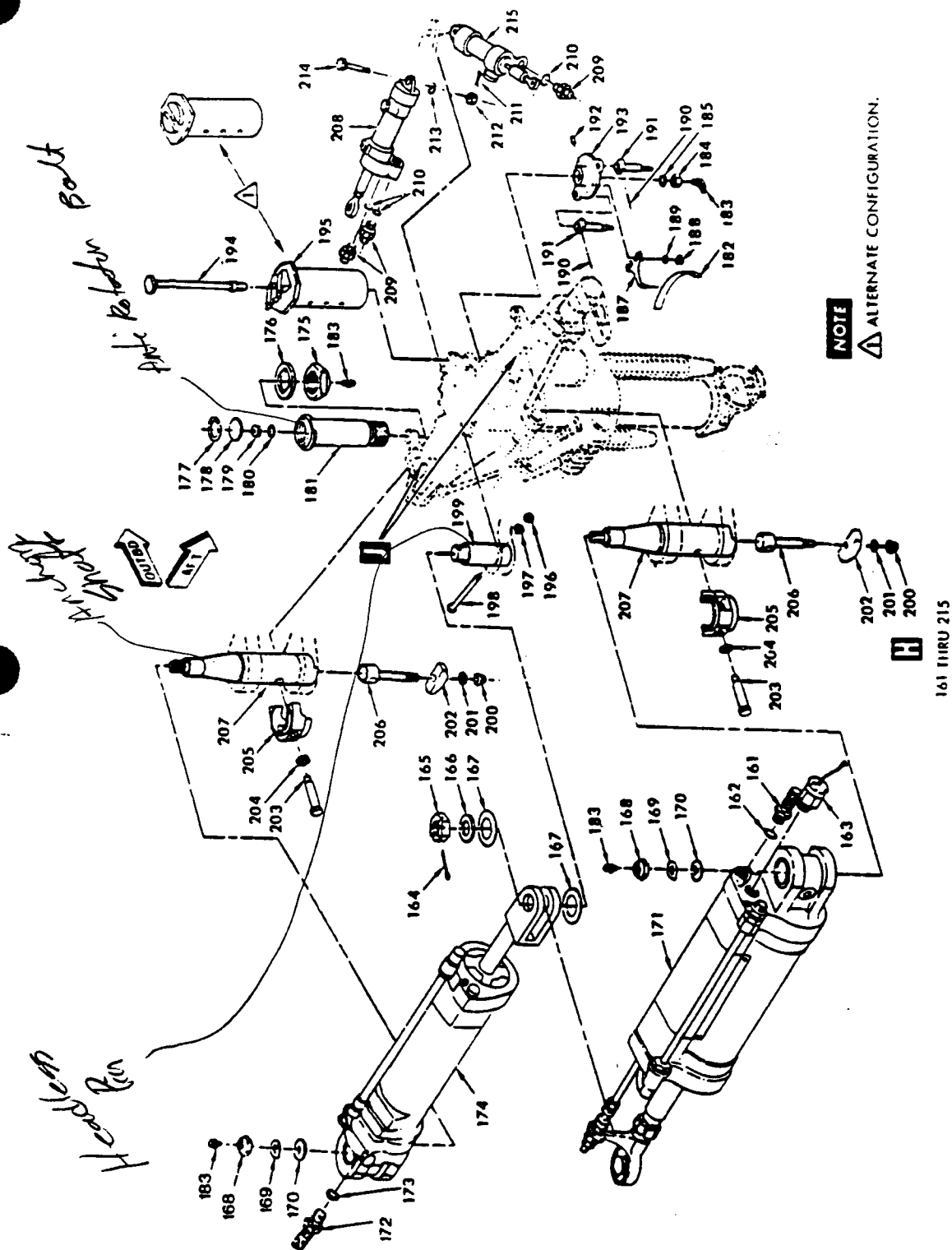


Figure 2-8. RH Aft Strut Assembly (Sheet 6 of 18)

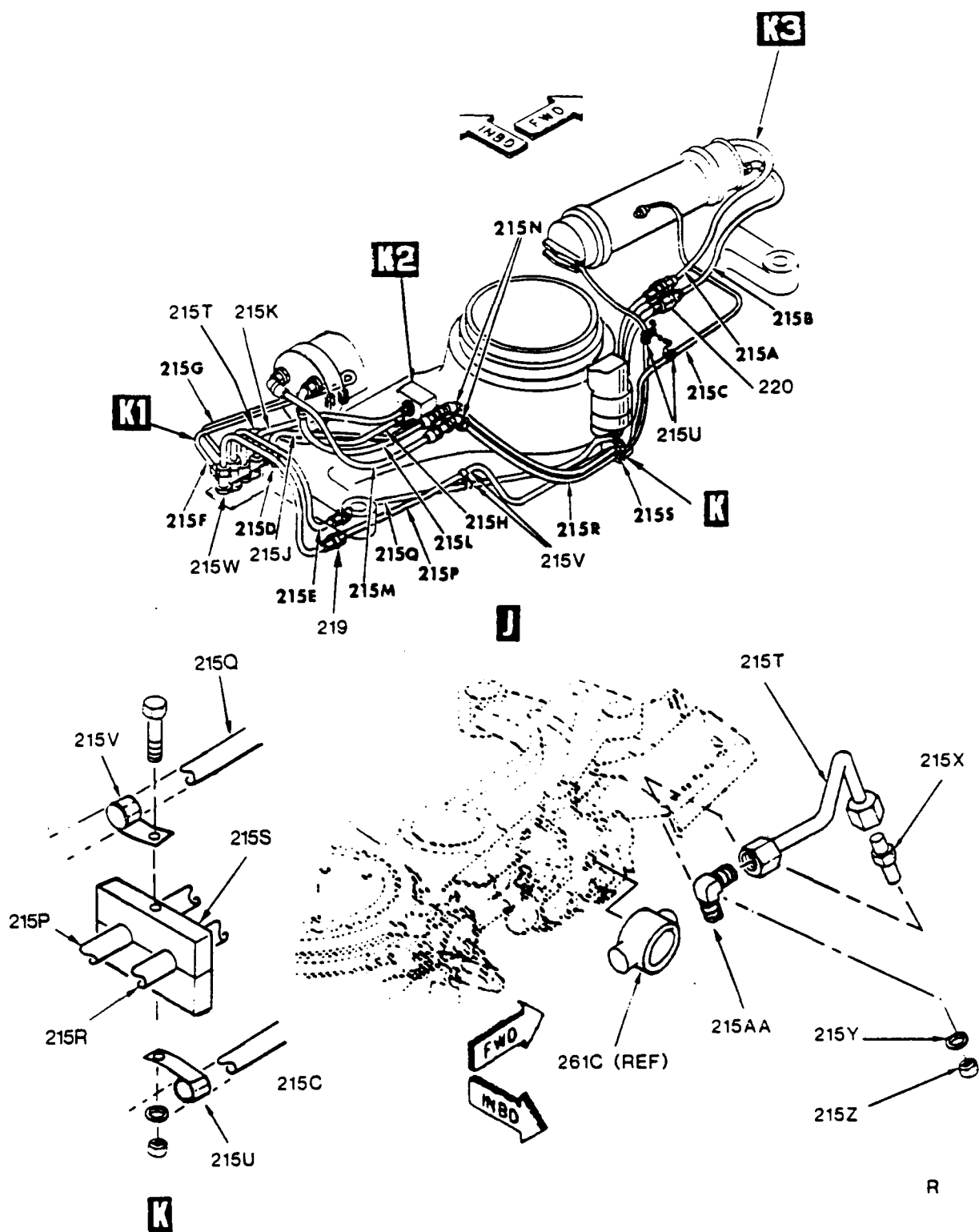


Figure 2-8. RH Aft Strut Assembly (Sheet 7 of 18)

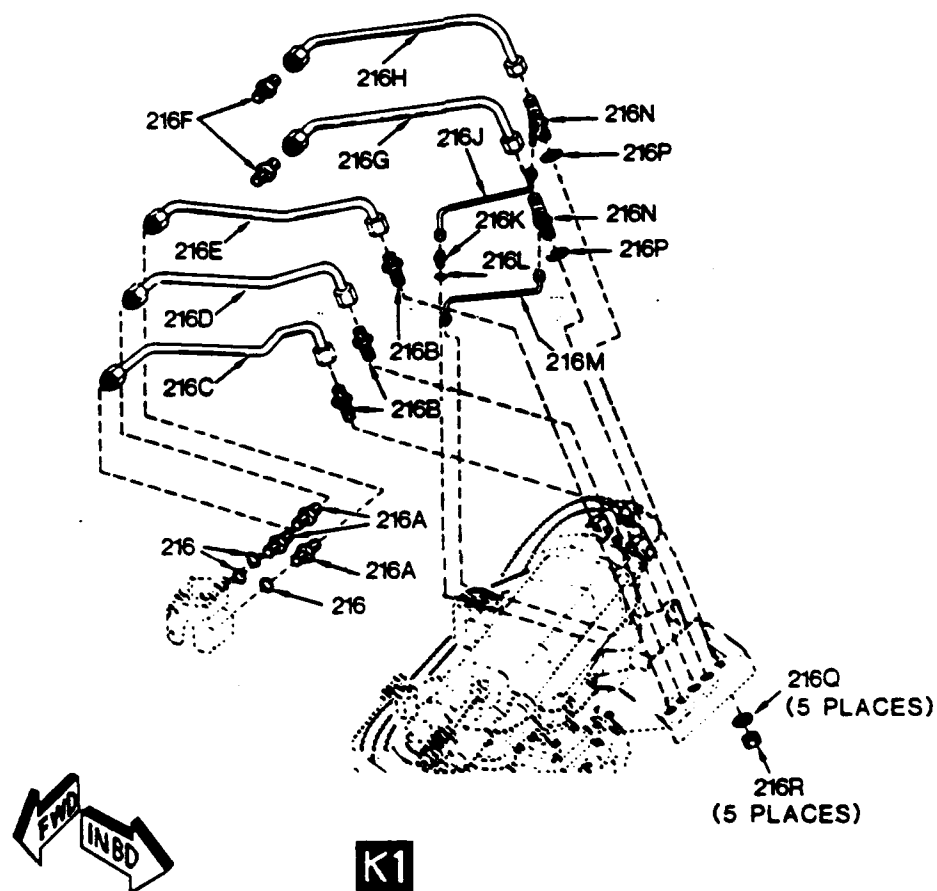


Figure 2-8. RH Aft Strut Assembly (Sheet 8 of 18)

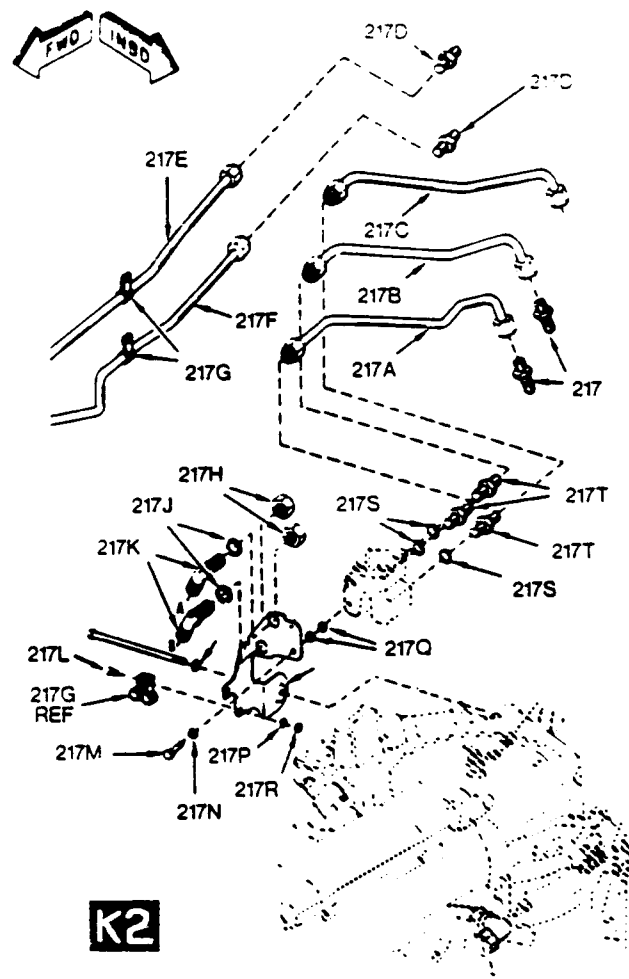


Figure 2-8. RH Aft Strut Assembly (Sheet 9 of 15)

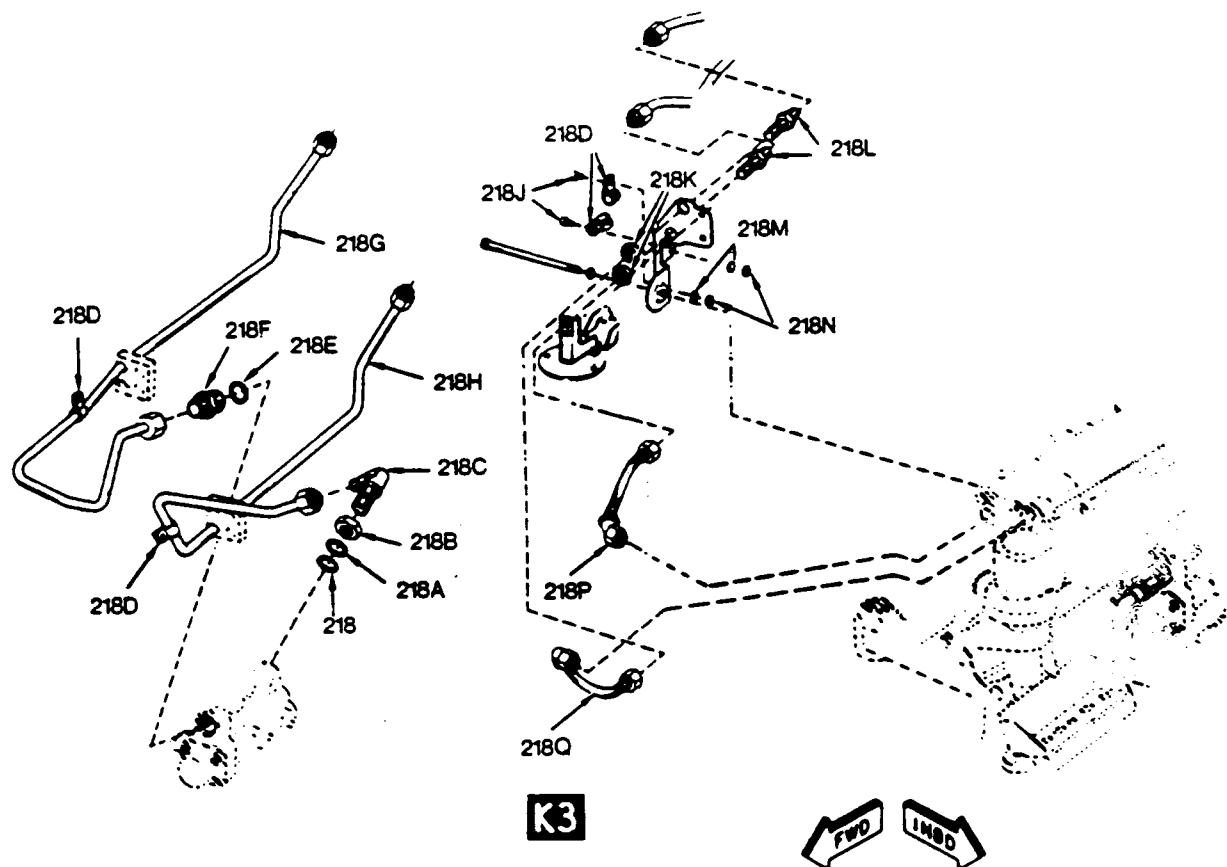


Figure 2-8. RH Aft Strut Assembly (Sheet 10 of 18)





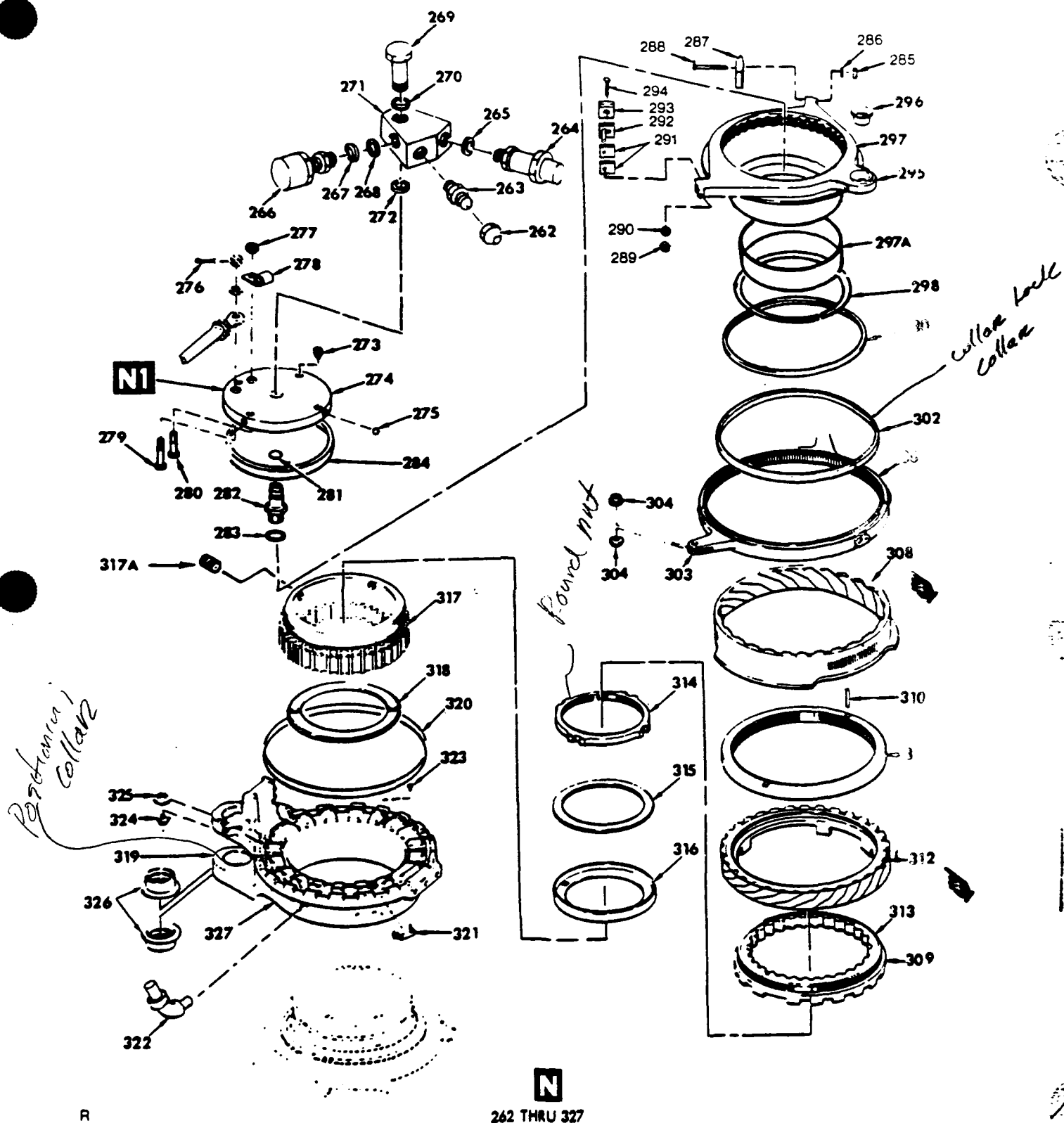
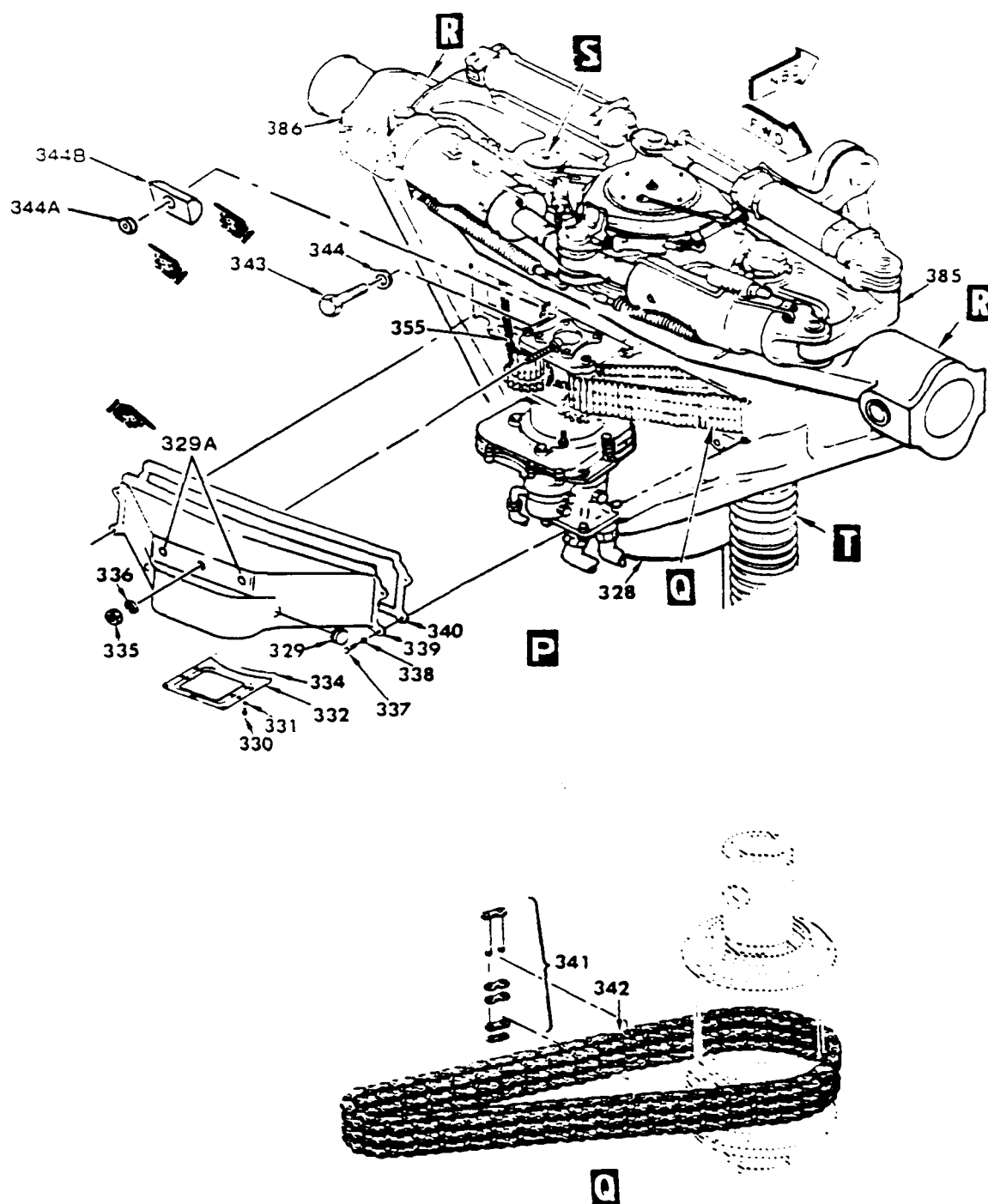


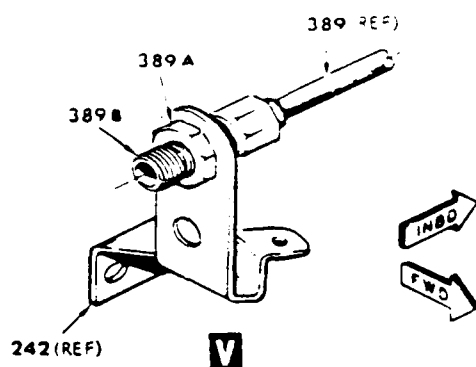
Figure 2-8. RH Aft Strut Assembly (Sheet 12 of 18)



328 THRU 344, 355

Figure 2-8. RH Aft Strut Assembly (Sheet 13 of 18)



**NOTE**

- 2 USE P/N 4G13633-01A BOLT WITH THIS CONFIGURATION ON APEX SHAFT.
- 3 USE P/N 4G13771-101A BOLT WITH THIS CONFIGURATION APEX SHAFT.

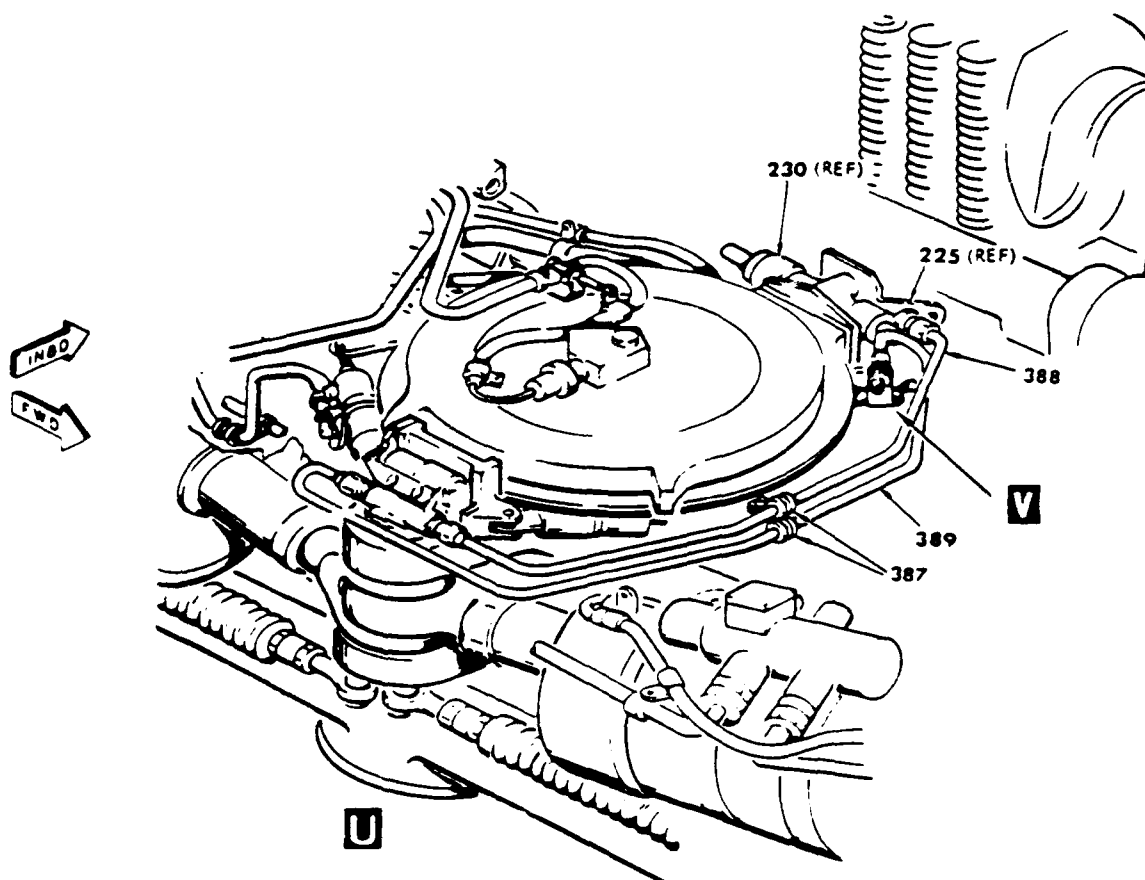


Figure 2-8. RH Aft Strut Assembly (Sheet 15 of 18)

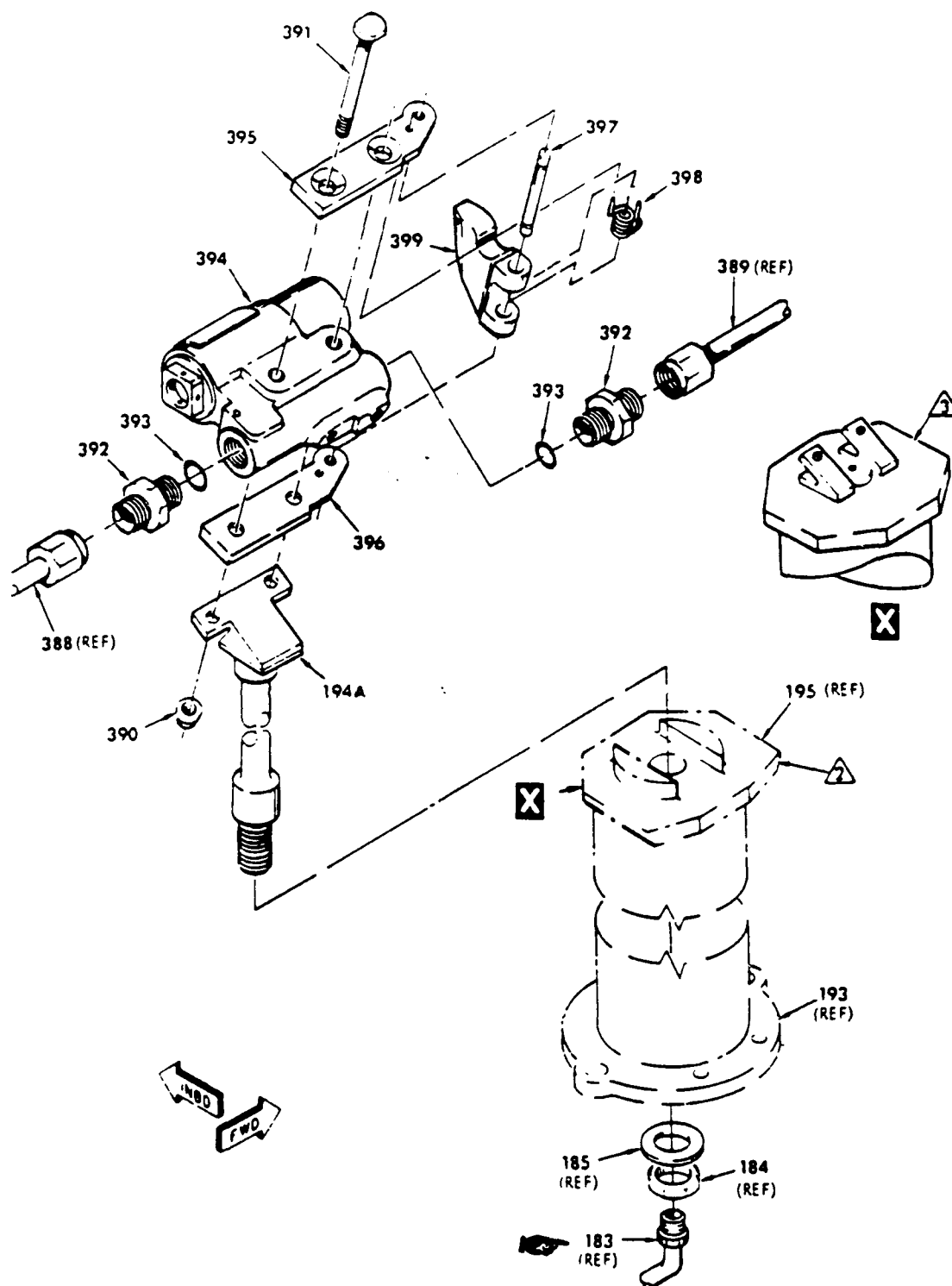


Figure 2-8. RH Aft Strut Assembly (Sheet 16 of 18)

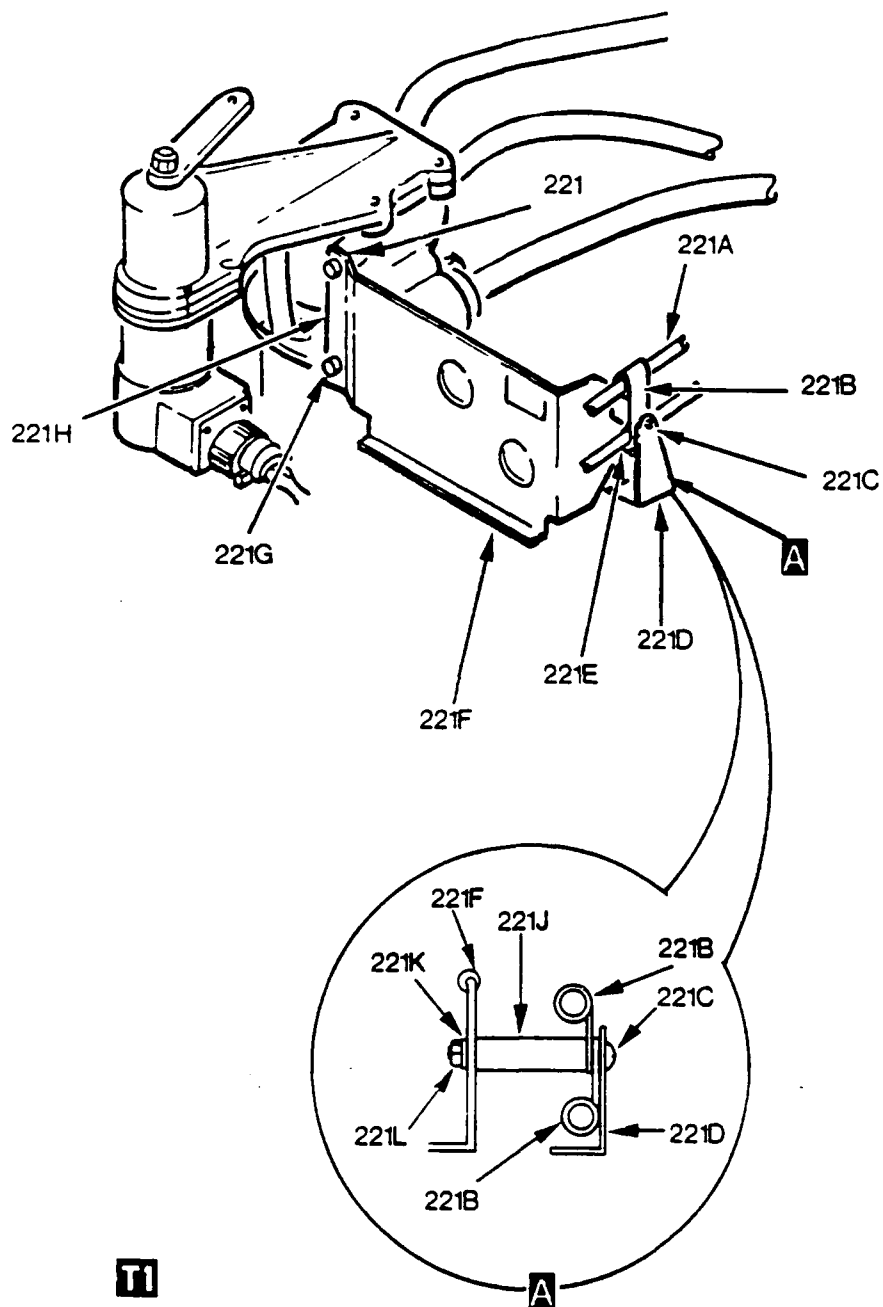
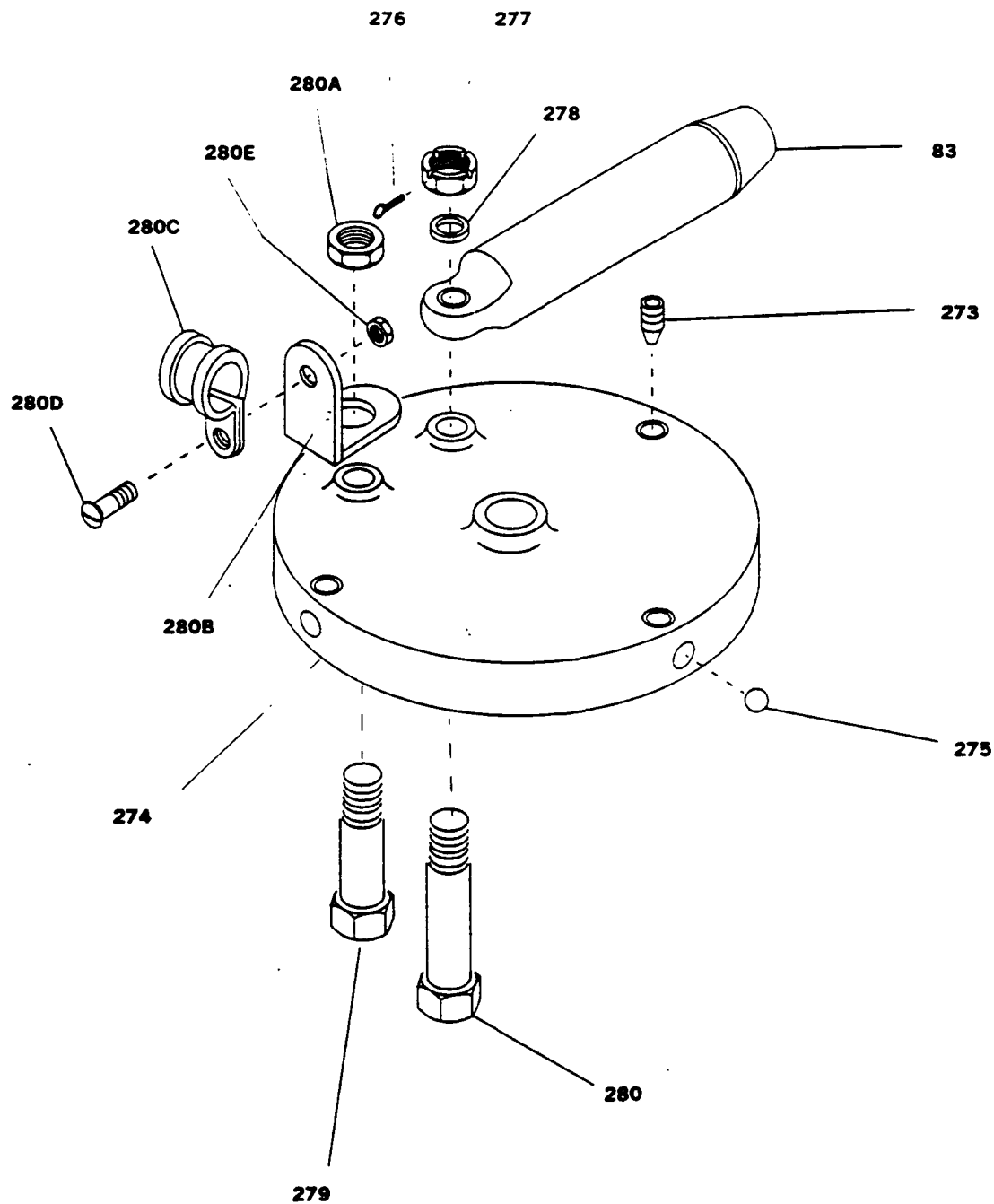


Figure 2-8 RH Aft Strut Assembly (Sheet 17 of 19)



**NI**

Figure 2-8. RH Aft Strut Assembly (Sheet 18 of 18)



FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
2-8.	4G11400-139A	98897	STRUT ASSEMBLY, RH AFT (See figure 2-1 for NHA)							REF		XA
-1	4G12400-101A	98897	TRUNNION PIN							1		PADDD
-1A	4G13999-101A	98897	SLEEVE, Shipping							1		PAOZZ
-2	4G13347-101A	98897	BOLT (AP)							1		PAOZZ
-3	AN960C3616	88044	WASHER (AP)							1		PAOZZ
-4	4G13346-101A	98897	WASHER, Lock (AP)							1		PAOZZ
-5	4G13332-101A	98897	NUT (AP)							1		PAOZZ
-6	NO NUMBER		RETRACT ARM, Built-up instl (see figure 2-9)							NP		PAOZZ
-7	4G13347-101A	98897	BOLT (AP)							1		PAOZZ
-8	AN960C3616	88044	WASHER (AP)							1		PAOZZ
-9	4G13346-101A	98897	WASHER, Lock (AP)							1		PAOZZ
-10	4G13332-101A	98897	NUT (AP)							1		PAOZZ
-11	4G11008-123A	98897	TUBING INSTL, LH fwd (see figure 2-1 for NHA) (See figure 2-3 for breakdown)							REF		XC
-12	4869130-105A	98897	WIRING INSTL (See figure 2-1 for NHA) (See figure 2-15 for breakdown)							REF		PADLD
-13	DELETED											
-14	DELETED											
-15	DELETED											
-16	DELETED											
-17	DELETED											
-18	DELETED											
-19	DELETED											
-20	DELETED											
-21	DELETED											
-22	DELETED											
-23	DELETED											
-24	DELETED											
-25	NAS1634-16	80205	SCREW							1		PAOZZ
-26	Z1200	72962	NUT							1		PAOZZ
-27	4G14359-101A	98897	CLIP							2		PAOZZ
-28	MS21251B5S	96906	TURNBUCKLE (See figure 2-1 for NHA)							2		PAOZZ
-29	MS21256-1	96906	CLIP (See figure 2-1 for NHA)							4		PAOZZ
-30	MS24665-132	96906	PIN, Cotter (see figure 2-1 for NHA)							2		PAOZZ
-31	MS20392-2C13	96906	PIN, Clevis (see figure 2-1 for NHA)							2		PAOZZ
-32	NAS1106-20D	80205	BOLT (See figure 2-1 for NHA)							2		PAOZZ
-33	4G11005-121A	98897	CLAMP (See figure 2-1 for NHA)							1		PAFFF
-34	MS21042-6	96906	NUT (See figure 2-1 for NHA)							4		PAOZZ
-35	AN960D616	88044	WASHER (See figure 2-1 for NHA)							2		PAOZZ
-36	AN960D616L	88044	WASHER (See figure 2-1 for NHA)							2		PAOZZ
-37	NAS2806-20	80205	SCREW (See figure 2-1 for NHA)							4		PAOZZ
-38	4G14354-107A	98897	COLLAR, Forward (see figure 2-1 for NHA)							1		PAFZZ
-39	4G14355-103A	98897	COLLAR, Aft (see figure 2-1 for NHA)							1		PAFZZ
-40	MS21042-4	96906	NUT (See figure 2-1 for NHA)							2		PAOZZ
-41	AN960D416	88044	WASHER (See figure 2-1 for NHA)							2		PAOZZ
-42	NAS1634-9	80205	SCREW (See figure 2-1 for NHA)							2		PAOZZ
-43	4G14364-107A	98897	PLATE ASSEMBLY (See figure 2-1 for NHA)							1		PAFFF
-44	MS24665-132	96906	PIN, Cotter (see figure 2-1 for NHA)							2		PAOZZ
-45	MS21252-5LS	96906	CLEVIS (See figure 2-1 for NHA)							2		PAOZZ
-46	MS20392-3C15	96906	PIN, Clevis (see figure 2-1 for NHA)							2		PAOZZ
-47	LS5964R24-0122	98897	CABLE (See figure 2-1 for NHA)							2		PAOZZ
-48	NAS1624-9	80205	SCREW (See figure 2-1 for NHA)							2		PAOZZ
-49	MS21042-4	96906	NUT (See figure 2-1 for NHA)							2		PAOZZ
-50	AN960D416	88044	WASHER (See figure 2-1 for NHA)							2		PAOZZ
-51	MS21042-4	96906	NUT (See figure 2-1 for NHA)							1		PAOZZ
-52	AN960D416	88044	WASHER (See figure 2-1 for NHA)							1		PAOZZ
-53	NAS1634-3	80205	SCREW (See figure 2-1 for NHA)							1		PAOZZ
-54	4G14366-101A	98897	PLATE ASSEMBLY (See figure 2-1 for breakdown)							1		PAOZZ

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FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
2-8-105	MS21083D8	96906								2		PAOZZ
-106	4G13798-101A	98897								2		PAOZZ
-107	4G13799-101A	98897								8		PAOZZ
-108	4G12585-101A	98897								1		PAOFF
-109	MS21241-12A010	96906								2		PAOZZ
-110	4G12585-103A	98897								1		XA
-111	MS21083D5	96906								1		PAOZZ
-112	4G13803-101A	98897								1		PAOZZ
-113	4G12586-101A	98897								1		PAOFF
-114	MS21241-12A010	96906								2		PAOZZ
-115	4G12586-103A	98897								1		XA
-116	AN502-10-16	88044								2		PAOZZ
-117	4G11019-107A	98897								1		PAFZZ
-118	4G14394-101A	98897								1		PAFZZ
-119	AN3066-6	88044								1		PAOZZ
-120	AN3063-6	88044								1		PAOZZ
-121	AN3066-8	88044								2		PAOZZ
-122	AN3063-8	88044								2		PAOZZ
-123	MS25082-3	96906								3		PAOZZ
-124	MS21042-3	96906								2		PAOZZ
-125	MS35338-43	96906								3		PAOZZ
-126	AN960010	88044								2		PAOZZ
-127	NAS603-30P	80205								3		PAOZZ
-128	NAS603-72P	80205								2		PAOZZ
-128A	AN735D14	88044								1		PAOZZ
	MS24693S31	96906								1		PAOZZ
	NAS43DD1-28	80205								1		PAOZZ
	MS25082-1	96906								1		PAOZZ
	MS21042-06	96906								1		PAOZZ
-129	4869017-101A	98897								1		PAFZZ
-129A	AN735D14	88044								1		PAOZZ
	MS24693S31	96906								1		PAOZZ
	NAS43DD1-28	80205								1		PAOZZ
	MS25082-1	96906								1		PAOZZ
	MS21042-06	96906								1		PAOZZ
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-130A	4869024-101A	98897								1		PAFZZ
	NAS603-10P	80205								3		PAOZZ
	AN960D10	88044								3		PAOZZ
	MS21042-3	96906								3		PAOZZ
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	NAS601-10P	80205								3		PAOZZ
	AN960D6	88044								3		PAOZZ
	MS21042-06	96906								3		PAOZZ
-130C	4869021-101A	98897								1		PAFZZ
	NAS601-6P	80205								2		PAOZZ
-130D	4869019-102A	98897								1		PAFZZ
	NAS601-10P	80205								3		PAOZZ
	AN960D6	88044								3		PAOZZ
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-133	4G13800-101A	98897								4		PAOZZ
-134	MS21241-12A012	96906								1		PAOZZ
-135	MJ21241-08A012	96906								1		PAOZZ
-136	MS21241-09F1-15	96906								2		PAOZZ
-137	4G12583-103A	98897								1		PAFLD
-138	MS28774-126	96906								12		PAOZZ
-139	MS28775-126	96906								6		PAOZZ
-140	MS24266R1085SN	96906								2		PAOZZ
-141	NAS1104-18	80205								2		PAOZZ
-142	AN960C416L	88044								2		PAOZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
2-8-143	AN960C616L	88044	.	WASHER (See figure 2-1 for NHA) .....						2		PAOZZ
-144	R5	92830	.	WASHER (See figure 2-1 for NHA) .....						2		PAFZZ
-145	4G13790-101A	98897	.	SPACER (See figure 2-1 for NHA) .....						2		PAFZZ
-146	NAS577-4A	80205	.	NUT (See figure 2-1 for NHA) .....						2		PAOZZ
-147	MS21042-3	96906	.	NUT (See figure 2-1 for NHA) .....						2		PAOZZ
-148	AN960C10L	88044	.	WASHER (See figure 2-1 for NHA) .....						2		PAOZZ
-149	GM515200-1	22863	.	TRANSDUCER (See figure 2-1 for NHA) .....						2		PAOBZ
	4524-2701	18730	.	TRANSDUCER (Preferred spare for GM515200-1) .....						2		PAOBZ
-150	4G31003-101B	98897	.	CYLINDER, Positioning (see T.O. 4A6-6-3) .....						1		PAFLD
-151	4G31003-103B	98897	.	CYLINDER, Positioning (see T.O. 4A6-6-3) .....						1		PAFLD
-152	MS21042-3	96906	.	NUT (See figure 2-1 for NHA) .....						4		PAOZZ
-153	AN960C10L	88044	.	WASHER (See figure 2-1 for NHA) .....						4		PAOZZ
-154	NAS1303-6	80205	.	BOLT (See figure 2-1 for NHA) .....						4		PAOZZ
-155	MS21042-4	96906	.	UNION (See figure 2-1 for NHA) .....						8		PAOZZ
-156	MS28778-6	96906	.	PACKING (See figure 2-1 for NHA) .....						8		PAOZZ
-157	4G13085-123A	98897	.	PAD (See figure 2-1 for NHA) .....						4		MFFZZ
-158	420-75-625SH	98625	.	CLAMP (See figure 2-1 for NHA) .....						4		PAFFF
	MS21042-4	96906	.	NUT .....						1		PAOZZ
-159	4G14250-101A	98897	.	BRACKET (See figure 2-1 for NHA) .....						2		PAFZZ
-160	2690079	92003	.	VALVE (See T.O. 4BA4-100-3) (see figure 2-1 for NHA) .....						2		PAFZZ
-161	9R2220-1	99240	.	VALVE, Restrictor .....						1		PAFZZ
-162	MS28778-8	96906	.	PACKING .....						1		PAOZZ
-163	404EN64-6	91929	.	SWITCH .....						1		PAFZZ
-164	MS24665-378	96906	.	PIN, Cotter .....						1		PAOZZ
-165	55NE4717-162	72962	.	NUT (AN320-16 suitable substitute) .....						1		PAOZZ
-166	AN960-1616	88044	.	WASHER .....						1		PAOZZ
-167	4G13904-101A	98897	.	SHIM .....						2		PAOZZ
-168	55LH7644-108	72962	.	NUT .....						2		PAOZZ
-169	4G13372-101A	98897	.	WASHER, Keyed .....						2		PAOZZ
-170	4G13370-101A	98897	.	SPACER .....						2		PAOZZ
-171	4G11478-109A	98897	.	CYLINDER, Normal rotation (see T.O. 9H2-2-100-43) .....						1		PAFLD
-172	MS21924J8	96906	.	UNION .....						1		PAOZZ
-173	MS28778-8	96906	.	PACKING .....						1		PAOZZ
-174	4G11481-101C	98897	.	CYLINDER, Emergency rotation (see T.O. 9H2-2-100-53) .....						1		PAFLD
-175	55LH7644-202	72962	.	NUT .....						2		PAOZZ
-176	4G13617-101A	98897	.	WASHER, Anti-rotation .....						2		PAFZZ
-177	MS16625-1137	96906	.	RING, Snap .....						2		PAOZZ
-178	4G13618-101A	98897	.	DISC, Grease seal .....						2		MFFZZ
-179	4G13392-101A	98897	.	PLUG, Grease retainer .....						2		PAOZZ
-180	MS28775-017	96906	.	PACKING .....						2		PAOZZ
-181	4G12433-101A	98897	.	BOLT, Special .....						2		PAFDD
-182	4G13791-101A	98897	.	PROTRACTOR, Pos indicator .....						1		PAOZZ
-183	MS15001-4	96906	.	FITTING .....						5		PAOZZ
-184	NAS1291X8	80205	.	NUT .....						1		PAOZZ
-185	AN960-816	88044	.	WASHER .....						1		PAOZZ
-186	DELETED											
-187	4G13792-101A	98897	.	POINTER, Pos indicator .....						1		PAOZZ
-188	NAS1191-3P6	80205	.	SCREW .....						2		PAOZZ
-189	AN960-10L	88044	.	WASHER .....						2		PAOZZ
	4G12660-101A	98897	.	PLUG, Apex shaft, assembly .....						1		PAOZZ
-190	4G13766-101A	98897	.	PIN .....						2		PAOZZ
-191	4G13345-101A	98897	.	TRANSDUCER MOUNT FITTING .....						2		PAOZZ
-192	4G13767-101A	98897	.	PIN ANTI-ROTATION .....						1		XAFZZ
-193	4G13949-101A	98897	.	PLUG .....						1		PAOZZ
-194	4G13771-101A	98897	.	BOLT, Special .....						1		PAFFF
-194A	4G14633-101A	98897	.	BOLT .....						1		PAFZZ
-195	4G13561-101A	98897	.	SHAFT, Apex .....						1		PAFDD
-196	MS21042-4	96906	.	NUT .....						1		PAOZZ
-197	AN960-416	88044	.	WASHER .....						1		PAOZZ
-198	NAS1104-52	80205	.	BOLT .....						1		PAOZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMP CODE
2-8-199	4G13646-103B- 856045-01	98897 98747	PIN, Headless..... PIN, Headless, (preferred spare for ..... 4G13646-103B)	1 1		PAFBZ PAFBZ
-200	H29649-6	15653	NUT.....	2		PAOZZ
-201	AN960-616	88044	WASHER.....	2		PAOZZ
-202	4G13379-101A	98897	PLATE, Shaft retainer.....	2		PAOZZ
-203	4G13376-103A	98897	BOLT, Special.....	2		PAOZZ
-204	AN960PD816	88044	WASHER.....	2		PAOZZ
-205	4G13378-101A	98897	SPACER.....	2		PAOZZ
	4G13378-103A	98897	SPACER (Preferred spare for ..... 4G13378-101A)	2		PAOZZ
-206	4G13377-101A	98897	FITTING, Retainer shaft.....	2		PAOZZ
-207	4G13366-101A	98897	SHAFT, Rotation cylinder.....	2		PAOZZ
-208	4G11454-101D	98897	LOCK CYLINDER, Normal.....	1		PAFDD
-209	MS21902J4	96906	UNION.....	3		PAOZZ
-210	MS28778-4	96906	PACKING.....	3		PAOZZ
-211	MS24665-153	96906	PIN, Cotter.....	4		PAOZZ
-212	AN320-4	88044	NUT.....	4		PAOZZ
-213	AN960-416	88044	WASHER.....	4		PAOZZ
-214	NAS1104-13D	80205	BOLT.....	4		PAOZZ
-215	4G14563-101A	98897	CYLINDER ASSEMBLY (See T.O..... 9H2-2-100-13)	1		PAFDD
-215A	MS27372H0240124	96906	HOSE ASSEMBLY.....	1		PAOZZ
-215B	MS27373H0172000	96906	HOSE ASSEMBLY.....	1		PAOZZ
-215C	T4G04104-165A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-215D	T4G04104-125A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-215E	T4G04104-127A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-215F	T4G04104-129A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-215G	T4G04104-131A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-215H	T4G04104-133A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-215J	T4G04104-135A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-215K	T4G04104-137A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-215L	MS27371H0176	96906	HOSE ASSEMBLY.....	1		PAOZZ
-215M	MS27371H0214	96906	HOSE ASSEMBLY.....	1		PAOZZ
-215N	AS1010J0810	81343	ELBOW.....	2		PAOZZ
-215P	4G12517-101A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-215Q	4G12518-101A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-215R	4G12520-101A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-215S	4G12559-101A	98897	BLOCK ASSEMBLY, Clamp.....	1		PAOZZ
	4G12559-101B	98897	BLOCK ASSEMBLY, Clamp..... (preferred spare for 4G12559-101A)	1		PAOZZ
	NAS1303-20	80205	BOLT (AP).....	1		PAOZZ
	LS5984S3M	98897	WASHER PLAIN (Reduced OD) (AP).....	1		PAOZZ
	MS21042-3	96906	NUT (AP).....	1		PAOZZ
-215T	T4G04104-143A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-215U	MS21919WDG10	96906	CLAMP.....	3		PAOZZ
	MS24678-10	96906	SCREW (AP).....	2		PAOZZ
	LS5984S3M	98897	WASHER (AP).....	2		PAOZZ
	MS21042-3	96906	NUT (AP).....	2		PAOZZ
-215V	MS21919WDG8	96906	CLAMP.....	3		PAOZZ
	MS24678-12	96906	SCREW (AP).....	1		PAOZZ
	LS5984S3M	98897	WASHER (AP).....	1		PAOZZ
	MS21042-3	96906	NUT (AP).....	1		PAOZZ
-215W	STSPB202J080804	98897	TEE.....	2		PAOZZ
-215X	2-01096F0806	11328	UNION.....	1		PAOZZ
-215Y	2-03014F08	11328	NUT (AP).....	1		PAOZZ
-215Z	NAS814-8	80205	CAP.....	1		PAOZZ
-215AA	ER2833J06	11328	ELBOW.....	1		PAOZZ
-216	MS28778-8	96906	PACKING.....	3		PAOZZ
-216A	MS21902J8	96906	UNION.....	3		PAOZZ
-216B	MS21924J8	96906	UNION.....	3		PAOZZ
-216C	T4G04104-133A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-216D	T4G04104-137A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-216E	T4G04104-135A	98897	TUBE ASSEMBLY.....	1		MFOZZ
-216F	MS21902J8	96906	UNION.....	2		PAOZZ
-216G	T4G04104-127A	98897	TUBE ASSEMBLY.....	1		MFOZZ

FIG & INDEX NO	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-216H	T4G04104-125A	98897	TUBE ASSEMBLY .....	1		MFOZZ
-216J	T4G04104-129A	98897	TUBE ASSEMBLY .....	1		MFOZZ
-216K	MS21902J4	96906	UNION .....	1		PAOZZ
-216L	MS28778-4	96906	PACKING .....	1		PAOZZ
-216M	T4G04104-131A	98897	TUBE ASSEMBLY .....	1		MFOZZ
-216N	STSPB202J080804	98897	TEE .....	2		PAOZZ
-216P	AN960PD1216	88044	WASHER .....	2		PAOZZ
-216Q	AN924-8D	88044	NUT .....	5		PAOZZ
-216R	NAS814-8	80205	CAP .....	5		PAOZZ
-217	MS21924J8	96906	UNION .....	3		PAOZZ
-217A	T4G04104-133A	98897	TUBE ASSEMBLY .....	1		MFOZZ
-217B	T4G04104-137A	98897	TUBE ASSEMBLY .....	1		MFOZZ
-217C	T4G04104-135A	98897	TUBE ASSEMBLY .....	1		MFOZZ
-217D	MS21902J8	96906	UNION .....	2		PAOZZ
-217E	4G12517-101A	98897	TUBE ASSEMBLY .....	1		MFOZZ
-217F	4G12518-101A	98897	TUBE ASSEMBLY .....	1		MFOZZ
-217G	MS21919WDG8	96906	CLAMP .....	2		PAOZZ
-217H	AN924-8D	88044	NUT .....	2		PAOZZ
-217J	AN960PD1216	88044	WASHER .....	2		PAOZZ
-217K	STSPB102J0810	98897	ELBOW .....	2		PAOZZ
-217L	MS24678-12	96906	SCREW .....	1		PAOZZ
-217M	NAS1304-4H	80205	BOLT .....	2		PAOZZ
-217N	AN960-416	88044	WASHER .....	2		PAOZZ
-217P	LS598453M	98897	WASHER .....	1		PAOZZ
-217Q	AN960-416	88044	WASHER (Maximum 2 used as shim) ....	2		PAOZZ
-217R	MS21042-3	96906	NUT .....	1		PAOZZ
-217S	MS28778-8	96906	PACKING .....	3		PAOZZ
-217T	MS21902J8	96906	UNION .....	3		PAOZZ
-218	MS28778-10	96906	PACKING .....	1		PAOZZ
-218A	MS28773-10	96906	RETAINER .....	1		PAOZZ
-218B	AN6289J10	88044	NUT .....	1		PAOZZ
-218C	MS21908J10	96906	ELBOW .....	1		PAOZZ
-218D	MS21919WDG10	96906	CLAMP .....	2		PAOZZ
-218E	MS28778-10	96906	PACKING .....	1		PAOZZ
-218F	9R2220-3	99240	RESTRICTOR VALVE .....	1		PAOZZ
-218G	T4G04104-165A	98897	TUBE ASSEMBLY .....	1		MFOZZ
-218H	4G12520-101A	98897	TUBE ASSEMBLY .....	1		MFOZZ
-218J	MS24678-10	96906	SCREW .....	2		PAOZZ
-218K	AN924-8D	88044	NUT .....	2		PAOZZ
-218L	MS21924J8	96906	UNION .....	2		PAOZZ
-218M	LS598453M	98897	WASHER .....	2		PAOZZ
-218N	MS21042-3	96906	NUT .....	2		PAOZZ
-218P	MS27373H0172000	96906	HOSE ASSEMBLY .....	1		PAOZZ
-218Q	MS27372H0240124	96906	HOSE ASSEMBLY .....	1		PAOZZ
-219	MS21902J8	96906	UNION .....	2		PAOZZ
-220	MS21924J8	96906	UNION .....	2		PAOZZ
-221	AN960-416	88044	WASHER (Maximum of 6) .....	6		PAOZZ
-221A	T4G04101-173A	98897	TUBE .....	REF		MFOZZ
-221B	MS21919WDG4	96906	CLAMP .....	2		PAOZZ
-221C	NAS1633-11	80205	SCREW .....	1		PAOZZ
	NAS603-16P	80205	SCREW (Preferred spare for .....	1		PAOZZ
			NAS1633-11)			
-221D	4G13708-101A	98897	BRACKET .....	1		PAOZZ
-221E	T4G04101-165A	98897	TUBE .....	REF		MFOZZ
-221F	4B69012-103A	98897	BRACKET (RH fwd) .....	1		PAOZZ
	4B69012-101A	98897	BRACKET (RH aft) .....	1		PAOZZ
-221G	NAS1304-4H	80205	BOLT .....	2		PAOZZ
	NAS1304-2H	80205	BOLT (Optional, no spacers) .....	2		PAOZZ
-221H	4B69008-113A	98897	SPACER .....	1		PAOZZ
-221J	4B69008-115A	98897	SPACER (Altered from .....	1		PAOZZ
			NAS43DD3-22)			
-221K	AN960C10L	88044	WASHER .....	1		PAOZZ
-221L	STSCD006-06	98897	NUT .....	1		PAOZZ
	MS21042-3	96906	NUT (Preferred spare for .....	1		PAOZZ
			STSCD006-06)			
-222	DELETED					
-223	NAS1304-22H	80205	BOLT .....	3		PAOZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
2-8-224	LS5984S4M	98897	.	.	.	.	.	.	.	3		PAOZZ
.225	4G13725-101A	98897	.	.	.	.	.	.	.	1		PAOZZ
.226	179-50076	14798	.	.	.	.	.	.	.	1		PAOZZ
.227	AN6289J4	88044	.	.	.	.	.	.	.	1		PAOZZ
.228	MS28773-04	96906	.	.	.	.	.	.	.	1		PAOZZ
.229	MS28778-4	96906	.	.	.	.	.	.	.	1		PAOZZ
.230	4G12645-101G	98897	.	.	.	.	.	.	.	1		PAFDD
			.	.	.	.	.	.	.			
.231	NAS1306-1H	80205	.	.	.	.	.	.	.	2		PAOZZ
.232	4G13661-101A	98897	.	.	.	.	.	.	.	1		PAOZZ
.233	NAS509-4	80205	.	.	.	.	.	.	.	4		PAOZZ
.234	4G13574-101A	98897	.	.	.	.	.	.	.	2		PAOZZ
.235	NAS509-4	80205	.	.	.	.	.	.	.	4		PAOZZ
.236	4G14406-101A	98897	.	.	.	.	.	.	.	4		PAOZZ
.237	AN960PD416L	88044	.	.	.	.	.	.	.	4		PAOZZ
.238	4G13572-103A	98897	.	.	.	.	.	.	.	1		PAOZZ
.239	4G13572-104A	98897	.	.	.	.	.	.	.	1		PAOZZ
.240	NAS1304-1HW	80205	.	.	.	.	.	.	.	2		PAOZZ
.241	AN960-416	88044	.	.	.	.	.	.	.	2		PAOZZ
.242	4G12536-101A	98897	.	.	.	.	.	.	.	1		PAOZZ
.243	4G13337-101A	98897	.	.	.	.	.	.	.	1		PAOZZ
.244	4G11441-101A	98897	.	.	.	.	.	.	.	1		PAFDD
			.	.	.	.	.	.	.			
	4G13701-101A	98897	.	.	.	.	.	.	.	1		PAFDD
			.	.	.	.	.	.	.			
.244A	9R2220-3	99240	.	.	.	.	.	.	.	REF		PAOZZ
.244B	MS28778-10	96906	.	.	.	.	.	.	.	REF		PAOZZ
.245	NAS6205-13D	80205	.	.	.	.	.	.	.	3		PAOZZ
.246	4G13708-101A	98897	.	.	.	.	.	.	.	2		PAOZZ
.247	4G11458-103A	98897	.	.	.	.	.	.	.	1		XC
			.	.	.	.	.	.	.			
.247A	DELETED		.	.	.	.	.	.	.			
.247B	22266780	81873	.	.	.	.	.	.	.	1		PAFDD
.247C	4G12539-101A	98897	.	.	.	.	.	.	.	1		PAFDD
			.	.	.	.	.	.	.			
			.	.	.	.	.	.	.			
.248	MS21042-5	96906	.	.	.	.	.	.	.	6		PAOZZ
.249	AN960-516	88044	.	.	.	.	.	.	.	12		PAOZZ
.250	NAS6205-15D	80205	.	.	.	.	.	.	.	2		PAOZZ
.250A	NAS1305-14	80205	.	.	.	.	.	.	.	1		PAOZZ
.251	4G12043-101B	98897	.	.	.	.	.	.	.	1		PAOZZ
.252	4G12042-101A	98897	.	.	.	.	.	.	.	1		PAOZZ
.253	4G12042-102A	98897	.	.	.	.	.	.	.	1		PAOZZ
.254	MS21042-4	96906	.	.	.	.	.	.	.	2		PAOZZ
.255	LS5984S4M	98897	.	.	.	.	.	.	.	2		PAOZZ
.256	AN960-416	88044	.	.	.	.	.	.	.	2		PAOZZ
.257	NAS1104-12	80205	.	.	.	.	.	.	.	2		PAOZZ
.258	MS21042-4	96906	.	.	.	.	.	.	.	4		PAOZZ
.259	LS5984S4M	98897	.	.	.	.	.	.	.	4		PAOZZ
.260	AN960-416	88044	.	.	.	.	.	.	.	4		PAOZZ
			.	.	.	.	.	.	.			
.261	NAS1104-8	80205	.	.	.	.	.	.	.	4		PAOZZ
.261A	4G14360-101A	98897	.	.	.	.	.	.	.	3		PAOZZ
.261B	MS28775-115	96906	.	.	.	.	.	.	.	3		PAOZZ
.261C	4G14361-101A	98897	.	.	.	.	.	.	.	1		PAOZZ
.261D	4G14363-101A	98897	.	.	.	.	.	.	.	1		PAOZZ
.261E	4G14362-101A	98897	.	.	.	.	.	.	.	1		PAOZZ
.261F	MS28778-10	96906	.	.	.	.	.	.	.	3		PAOZZ
.261G	STSRB001D0810	98897	.	.	.	.	.	.	.	1		PADZZ
	GA7461D0810	50276	.	.	.	.	.	.	.	1		PADZZ
			.	.	.	.	.	.	.			
.262	MS28013-1	96906	.	.	.	.	.	.	.	1		PAOZZ
.263	MS28889-1	96906	.	.	.	.	.	.	.	1		PAOZZ
.264	705617	24038	.	.	.	.	.	.	.	1		PAOZZ
	01-705617	24038	.	.	.	.	.	.	.	1		PAOZZ
.265	MS28778-4	96906	.	.	.	.	.	.	.	1		PAOZZ

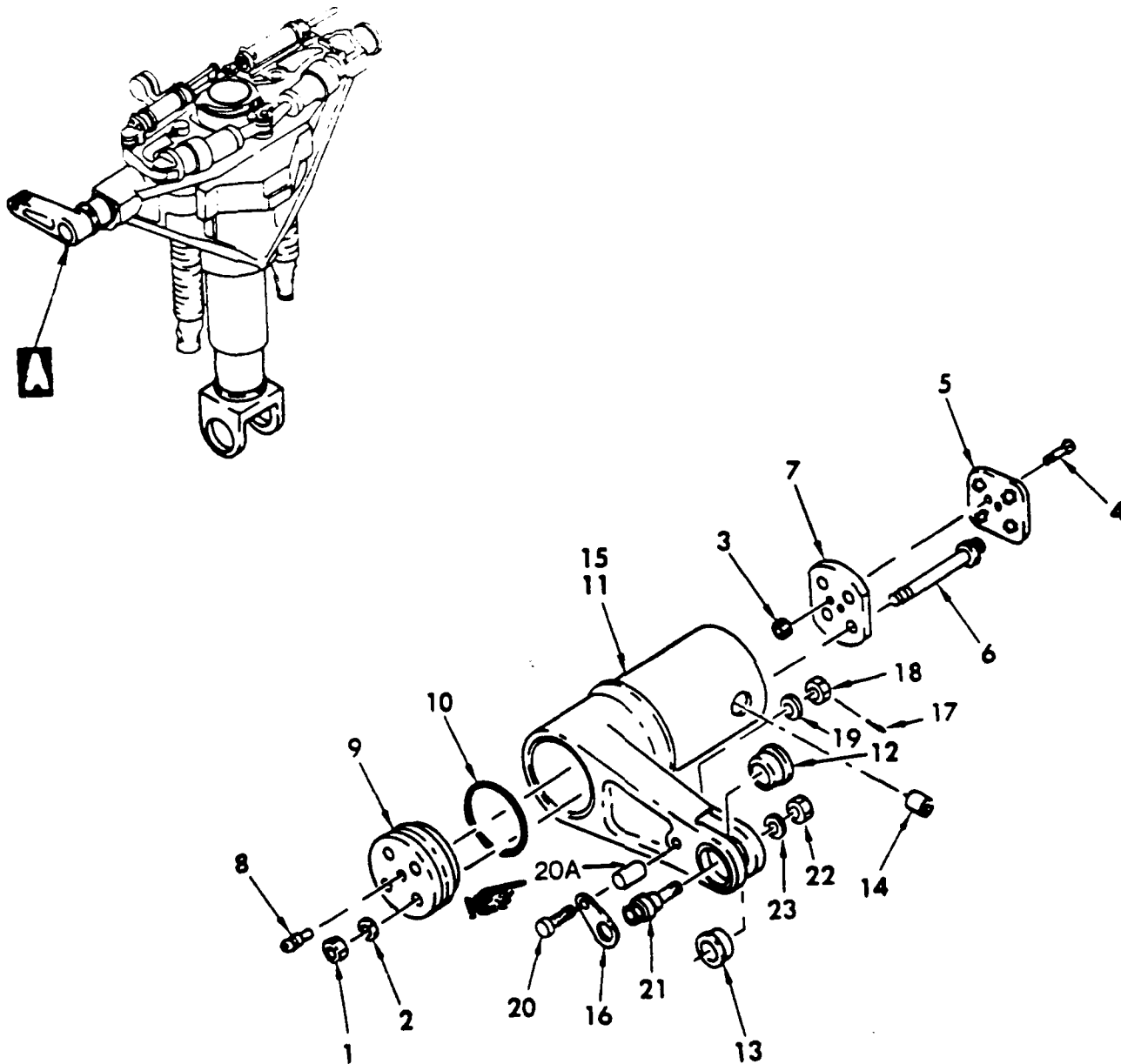
FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-266	G3714	34830	GAGE, Pressure (see figure 2-1 for..... NHA)	REF		PAFZZ
	1000-38	24708	GAGE, Pressure (alternate) .....	REF		PAFZZ
-267	MS28778-4	96906	PACKING.....	1		PAOZZ
-268	LS4764-4	98897	O-RING.....	1		PAFZZ
-269	NAS551-5H	80205	BOLT.....	1		PAOZZ
-270	MS28775-012	96906	PACKING.....	1		PAOZZ
-271	4G14322-101B	98897	FITTING.....	1		PAFZZ
-272	MS24690	96906	O-RING.....	1		PAOZZ
-273	4G13793-101A	98897	SCREW, Headless.....	4		PAOZZ
-274	4G13761-101A	98897	PLATE, Cover.....	1		PAOZZ
-275	MS19060-26	96906	BALL.....	4		PAOZZ
-276	MS24665-153	96906	COTTER PIN.....	1		PAOZZ
-277	MS17826-3	96906	NUT.....	1		PAOZZ
-278	AN960PD10L	88044	WASHER.....	2		PAOZZ
-279	NAS1303-14D	80205	BOLT.....	1		PAOZZ
-280	NAS1303-21D	80205	BOLT.....	1		PAOZZ
-280A	MS21042-3	96906	NUT.....	1		PAOZZ
-280B	AN743B12	88044	BRACKET.....	1		PAOZZ
-280C	MS21919WDG7	96906	CLAMP.....	1		PAOZZ
-280D	NAS603-8P	80205	SCREW.....	1		PAOZZ
-280E	MS21042-3	96906	NUT.....	1		PAOZZ
-281	MS28775-116	96906	PACKING.....	1		PAOZZ
-282	4G13524-105A	98897	STANDPIPE.....	1		PAFZZ
-283	MS28778-12	96906	PACKING.....	1		PAOZZ
-284	4G13419-101A	98897	NUT, Stop plate.....	1		PAOZZ
-285	MS21042-4	96906	NUT.....	1		PAOZZ
-286	AN960-416	88044	WASHER.....	1		PAOZZ
-287	4G13391-101A	98897	WEDGE.....	1		PAOZZ
-288	NAS1624-24	80205	SCREW.....	1		PAOZZ
-289	MS21042-4	96906	NUT.....	1		PAOZZ
-290	AN960-416	88044	WASHER.....	1		PAOZZ
-291	4G13769-101A	98897	SHIM, Stop pad.....	AR		PAOZZ
-291A	8852948-01	98747	SPACER, Stop pad.....	AR		PAOZZ
-291B	8852948-03	98747	SPACER, Stop pad.....	AR		PAOZZ
-292	4G12471-101A	98897	PLATE ASSEMBLY.....	1		PAOZZ
-293	4G13768-103A	98897	PAD, Stop.....	1		PAFFF
	856081-01	98897	PAD, Stop (preferred spare for..... 4G13768-103A)	1		PAOZZ
-294	4G13770-101A	98897	BOLT.....	1		PAOZZ
-295	4G11453-101B	98897	PLATE ASSEMBLY, Stop.....	1		PAFLD
-296	4G13575-103A	98897	BUSHING.....	1		PADZZ
	4G13575-105A	98897	BUSHING (preferred spare for..... 4G13575-103A)	1		PAOZZ
-297	4G11453-103B	98897	PLATE, Stop.....	1		XA
-297A	4G14605-101A	98897	BUSHING, Repair.....	1		PADZZ
-298	4G13420-101A	98897	WASHER, Segment.....	2		PAOZZ
-299	DELETED					
-300	DELETED					
-301	4G19074-101A	98897	BEARING, Thrust.....	1		PAFZZ
-302	4G13608-101A	98897	WIPER, Felt.....	1		PAOZZ
-303	4G11447-101A	98897	COLLAR ASSEMBLY, Lock actuator.....	1		PAFLD
-304	4G13609-103A	98897	BUSHING, Flanged.....	4		PADZZ
	4G13609-105A	98897	BUSHING, Flanged (preferred..... spare for 4G13609-103A)	4		PADZZ
-305	4G11447-103A	98897	COLLAR, Lock actuator.....	1		PAFLD
-306	DELETED					
-307	DELETED					
-308	4G13563-103A	98897	INSERT.....	1		PAFDD
-309	4G12636-101A	98897	RING ASSEMBLY, Lock.....	1		PAFDD
-310	4G13683-101A	98897	PIN.....	2		PAOZZ
-311	4G13571-101A	98897	NUT, Round.....	1		PAFZZ
-312	4G13569-101A	98897	GUIDE.....	1		XAFZZ
-313	4G13412-101A	98897	RING, Lock.....	1		PAOZZ
-314	4G13614-101A	98897	NUT, Round.....	1		PAOZZ
-315	4G13970-101A	98897	WASHER.....	1		PAOZZ
-316	4G13613-101A	98897	WASHER, Cup.....	1		PAOZZ



FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
2-8-317	4G13565-101B	98897								1		PAOZZ
.317A	8341244-01	98897								4		PAOZZ
.318	KJT111099V	50632								2		PAOZZ
	4G94432-103A	98897								2		PAOZZ
.319	4G11476-101B	98897								1		PAFDD
	4G11476-107A	98897								1		PAFDD
.320	4G12434-101A	98897								1		PAFZZ
.321	4G13311-101A	98897								18		PAOZZ
.322	MS15001-4	96906								2		PAOZZ
.323	4G13312-101A	98897								3		PADZZ
.324	4G13609-103A	98897								2		PADZZ
	4G13609-105A	98897								2		PADZZ
.325	4G13338-103A	98897								2		PADZZ
.326	4G13610-103A	98897								2		PADZZ
	4G13610-105A	98897								2		PADZZ
.327	4G11476-103A	98897								1		XA
	4G11476-109A	98897								1		XA
.328	NO NUMBER									NP		XA
.329	SS48175	61864								2		PAFZZ
.329A	SS48155	61864								2		PAOZZ
.330	NAS1304-1HW	80205								4		PAOZZ
.331	4G13669-101A	98897								4		PAOZZ
.332	4G12436-107A	98897								1		PAOZZ
.333	4G12436-109A	98897								1		XA
.334	4G12436-105A	98897								1		MFFZZ
.335	MS21042-4	96906								1		PAOZZ
.336	AN970-4	88044								1		PAOZZ
.337	MS21295-50	96906								6		PAOZZ
	NAS1351C4LN14	80205								6		PAOZZ
.338	AN960-416	88044								6		PAOZZ
.339	4G12627-107B	98897								1		PAFFF
.340	4G12627-105A	98897								1		MFFZZ
.341	TRIPLE 148C/L	72625								2		PAFZZ
	E50CLRC50-3CL	72625								2		PAFZZ
.342	TRIPLE 148	72625								2		PAFZZ
.343	NAS1308-26	80205								4		PAOZZ
.344	AN960-816	88044								4		PAOZZ
.344A	4G13687-101A	98897								AR		PAOZZ
.344B	NAS577-8A	80205								4		PAOZZ
.345	MS21042-5	96906								2		PAOZZ
.346	AN5-66A	88044								2		PAOZZ
.347	MS27183-12	96906								4		PAOZZ
.347A	4G13706-102A	98897								1		PAOZZ
	4G12049-102A	98897								1		PAOZZ
.347B	4G12050-102A	98897								1		PAFZZ
.347C	4G13706-101A	98897								1		PAOZZ
	4G12049-101A	98897								1		PAFZZ
.347D	4G12050-101A	98897								1		PAFZZ
.348	4G13606-101A	98897								2		PAOZZ
	4G12048-101A	98897								2		PAFZZ
.349	MS21042-3	96906								2		PAOZZ
.349A	AN960-10	88044								2		PAOZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-8-349B	NAS1103-4	80205	BOLT (Used with 4G12049-101A ..... and -102A)	2		PAOZZ
-350	DELETED					
-351	DELETED					
-352	DELETED					
-353	DELETED					
-354	4G12657-101B	98897	INSERT ASSEMBLY, Elect & hyd ..... service (aft ballscrew only)	1		PADLD
	4G12051-101A	98897	INSERT ASSEMBLY, Elect & hyd ..... service (aft ballscrew only) (pre- ferred spare for 4G12657-101B)	1		PADLD
-354A	KPSE65057-392	71468	CONNECTOR PLUG .....	1		PAOZZ
-354B	KPSE65057-392W	71468	CONNECTOR PLUG .....	1		PAOZZ
-355	4G11416-101B	98897	BALLSCREW DRIVE HOUSING ..... ASSEMBLY	1		PADLD
	4G11416-101C	98897	BALLSCREW DRIVE HOUSING ..... ASSEMBLY (Preferred spare for 4G11416-101B)	1		PADLD
-356	B15576-12	00293	ADAPTER (Used with B15576 only)..... (fwd ballscrew only)	1		PAFZZ
	246-15	2J558	ADAPTER (Used with AB-246-000 ..... only) (fwd ballscrew only)	1		PAFZZ
-357	4G13335-101A	98897	PIN, Retaining (fwd ballscrew only) .....	1		PAOZZ
-358	102C1050	62793	NUT, Retaining (alternate ..... 4G14647-101A)	2		PAFZZ
-359	B15576-10	00293	NUT, Hex .....	2		PAOZZ
-360	B15576-13R	06298	STOP, Dog .....	2		PAFZZ
-361	DELETED					
-362	DELETED					
-363	MS21042-6	96906	NUT .....	2		PAOZZ
-364	AN960-616	88044	WASHER .....	4		PAOZZ
-365	NAS1106-20D	80205	BOLT .....	2		PAOZZ
-366	NAS1303-1H	80205	BOLT (See figure 2-4 for NHA) .....	4		PAOZZ
-367	4G14392-101B	98897	BRACKET (See figure 2-4 for NHA) .....	1		PAFZZ
-368	422EN1-2	91929	SWITCH (See figure 2-4 for NHA) .....	1		PAFZZ
-369	MS21042-3	96906	NUT (See figure 2-4 for NHA) .....	2		PAOZZ
-370	NAS623-3-7	80205	BOLT (See figure 2-4 for NHA) .....	2		PAOZZ
-371	4G14391-101A	98897	STOP (See figure 2-4 for NHA) .....	1		PAFZZ
-372	NAS1106-15	80205	BOLT .....	2		PAOZZ
-373	4G13600-101A	98897	RING, Retainer .....	2		PAOZZ
-374	4G13694-101A	98897	SHIM .....	2		PAOZZ
	4G13694-103A	98897	SHIM, Preferred spare, use in lieu of ..... 4G13694-101A	2		PAOZZ
-375	B7402B	80648	BEARING, Lower radial .....	2		PAFZZ
	11613001	32828	BEARING, Lower radial (alternate for ..... B7402B) (LASC 4G94406-101A)	2		PAFZZ
-376	MS24665-368	96906	PIN, Cotter .....	2		PAOZZ
-377	4G13431-101A	98897	NUT, Round .....	2		PAFZZ
-378	4G13696-101A	98897	KEY .....	8		PAOZZ
-379	4G13688-101	98897	SPACER, Keyed .....	2		PAOZZ
-380	4G13605-103A	98897	PIN, Ballscrew .....	2		PAOZZ
-381	AB-246-000	2J558	BALLSCREW ASSEMBLY (See T.O. .... 16G3-2-80-3) (LAC spec 4G94034-101B)	2		PADLD
	B15576B	00293	BALLSCREW ASSEMBLY (See T.O. .... 16G3-2-80-3) (LAC spec 4G94034-101B)	2		PADLD
-382	4G13586-101A	98897	SPROCKET .....	2		PAOZZ
-383	B7401B	80648	BEARING, Upper radial (LAC spec ..... 4G94405-101A)	2		PAFZZ
	11612001	32828	BEARING, Upper radial (alternate for ..... B7401B) (LAC spec 4G94405-101A)	2		PAFZZ
-384	B7374B	80648	BEARING, Thrust (LAC spec ..... 4G94404-101A)	2		PAFZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	MFG QTY
			1	2	3	4	5	6	7			
2-8.384	52RT02	03489	BEARING, Thrust (alternate for ..... B7374B) (LAC spec 4G94404-101A)							2		
.385	4G11415-107A	98897	CYLINDER ASSEMBLY, Outer (see ..... figure 2-12)							1		
	4G11415-107C	98897	CYLINDER ASSEMBLY, Outer (see ..... figure 2-12) (preferred spare for 4G11415-107A)							1		
.386	NO NUMBER		YOKE AND SIDE BRACE ASSEMBLY ..... (See figure 2-13)							NP		
.387	4G19093-107A	98897	CLAMP (Make from MS21919DG4) .....							1		
	AN502-416-16	88044	SCREW .....							1		
	NAS43004-32	80205	SPACER .....							1		
.388	4G14639-101A	98897	TUBE ASSEMBLY .....							1		
.389	4G14638-101A	98897	TUBE ASSEMBLY .....							1		
.389A	AN924-40	88044	NUT .....							1		
.389B	MS21924J4	96906	UNION .....							1		
.390	MS21042-4	96906	NUT .....							2		
.391	4G13968-103A	98897	BOLT .....							2		
.392	MS21902J4	96906	UNION .....							2		
.393	MS28778-4	96906	PACKING .....							2		
.394	4G12443-101A	98897	VALVE ASSEMBLY (See T.O. .... 9H8-9-40-3)							1		
.395	4G13487-101A	98897	PLATE .....							1		
.396	4G13487-102A	98897	PLATE .....							1		
.397	4G13488-101A	98897	PIN .....							1		
.398	4G13967-101A	98897	SPRING .....							1		
.399	4G14634-101A	98897	LEVER .....							1		



**A**

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Figure 2-9. Retract Arm Built-up Instl

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
2-9	NO NUMBER		RETRACT ARM BUILT-UP INSTL (See..... figures 2-5, 2-6, 2-7, and 2-8 for NHA)							REF		X
-1	LS35154-7	98897	NUT.....							4		PAFZZ
-2	LFLH7559-3	98159	WASHER (Alternate 70631-1032 or..... 2230-7)							4		PAFZZ
-3	H39269-3	15853	NUT.....							2		PAFZZ
-4	NAS603-24P	80205	SCREW.....							2		PAFZZ
-5	4G14505-101A	98897	LOCK PLATE.....							1		PAOZZ
-6	MS21250-07100	96906	BOLT.....							4		PAFZZ
-7	4G14507-101A	98897	RETAINER.....							1		PAFZZ
-8	MS15001-1	96906	FITTING, Grease.....							1		PAOZZ
-9	4G14506-101A	98897	DIAPHRAGM.....							1		PAFZZ
-10	MS28775-431	96906	PACKING.....							1		PAFZZ
-11	4G11448-107A	98897	RETRACT ARM ASSEMBLY.....							1		PAFLD
-12	4G13530-103A	98897	BUSHING, Flanged.....							1		PADZZ
	4G13530-105A	98897	BUSHING, Flanged (preferred..... spare for -103A)							1		PADZZ
-13	4G13529-103A	98897	BUSHING, Flanged.....							1		PADZZ
	4G13529-105A	98897	BUSHING, Flanged (preferred..... spare for -103A)							1		PADZZ
-14	4G14606-101A	98897	BUSHING.....							2		PADZZ
-15	4G11448-109A	98897	RETRACT ARM.....							1		PADLL
-16	4G13647-101A	98897	LOCK PLATE.....							1		PAOZZ
-17	MS24665-304	96906	PIN, Cotter.....							1		PAOZZ
-18	MS17826-8	96906	NUT.....							1		PAOZZ
-19	AN960-816	88044	WASHER.....							1		PAOZZ
-20	AN8-23	88044	BOLT.....							1		PAOZZ
-20A	66C33001-03ST02	98747	BUSHING, Repair.....							1		PADZZ
	8631422-01	98747	BUSHING, Repair (preferred, spare..... for 66C33001-03ST02)							1		PADZZ
-21	4G13648-101A	98897	PIN, Eccentric.....							1		PAFZZ
	4G13648-103A	98897	PIN, Eccentric (preferred spare for..... 4G13648-101A)							1		PAFZZ
-22	MS21803D20	96906	NUT.....							1		PAOZZ
-23	AN960-2116	88044	WASHER.....							1		PAOZZ

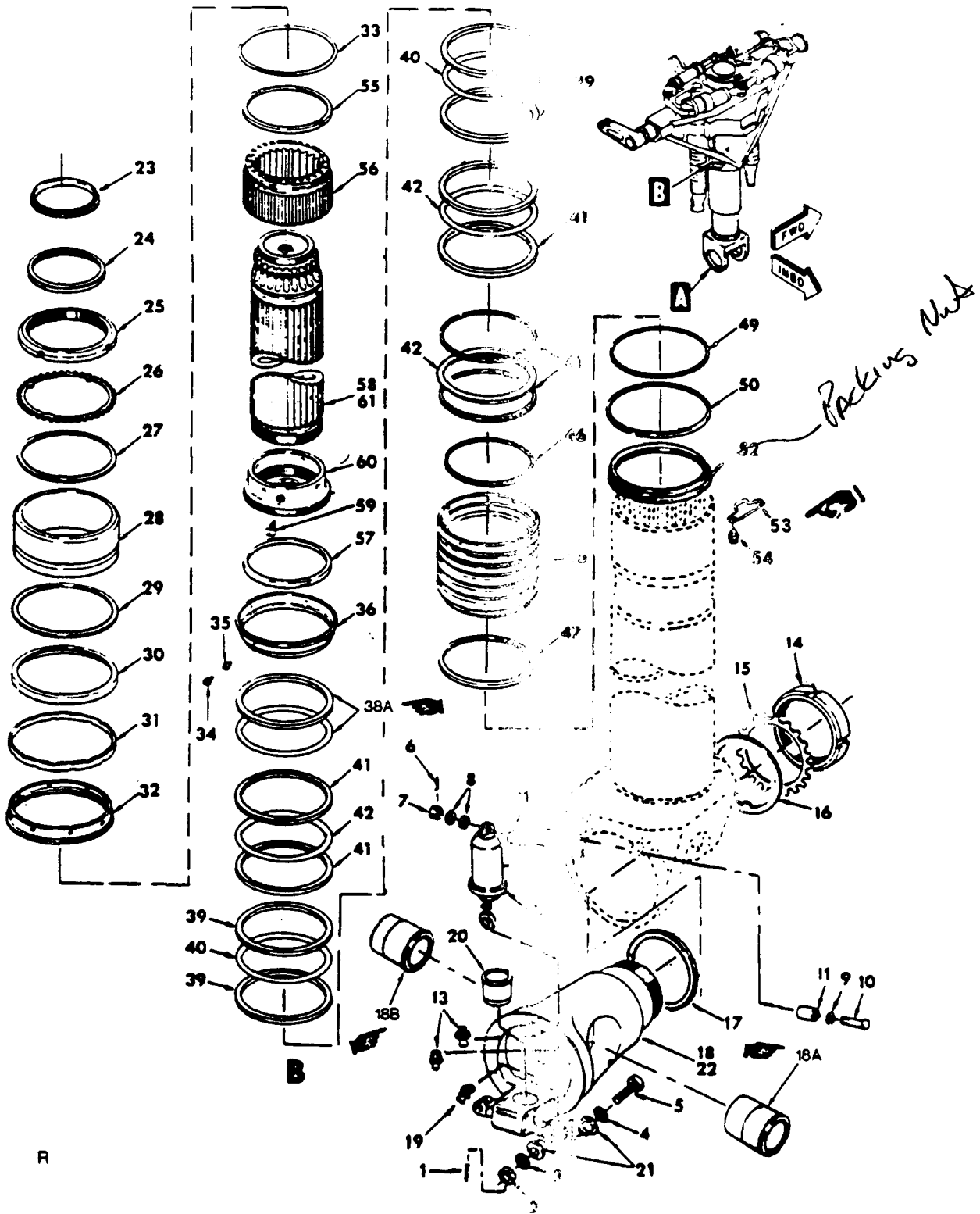


Figure 2-10. Piston Installation (Continued of 2)

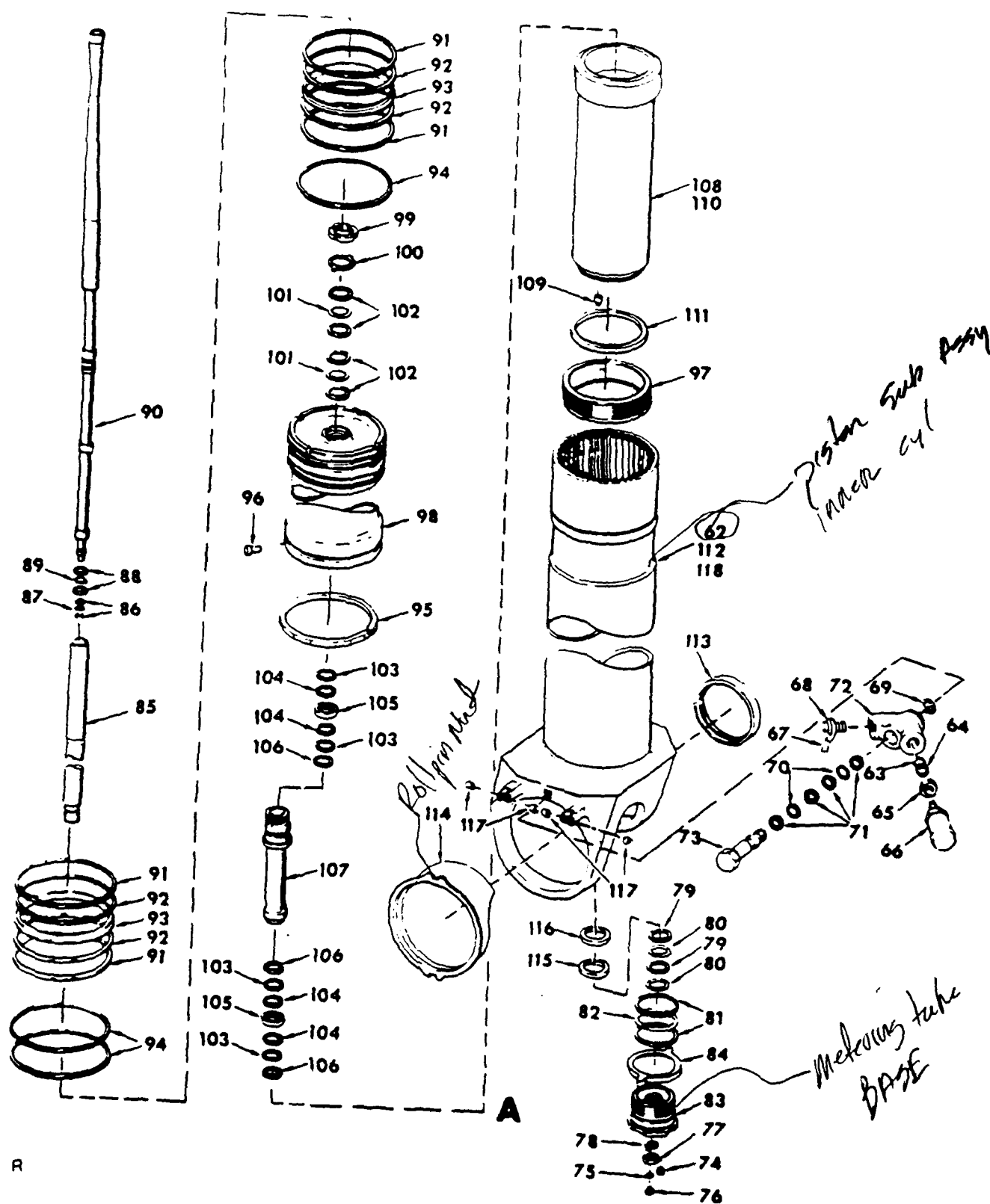


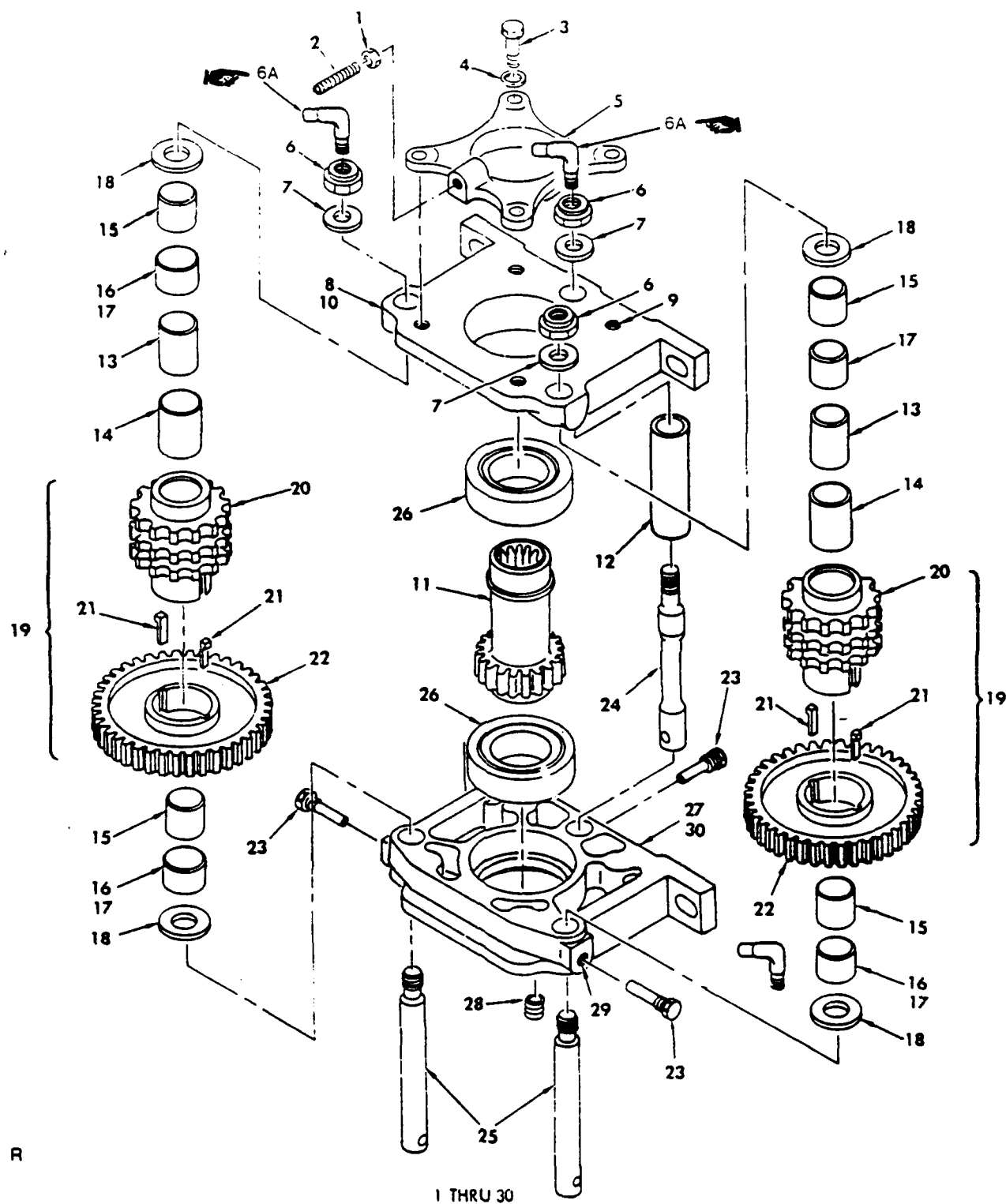
Figure 2.10. Piston Installation Sheet 2 of 2.

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
2-10-	NO NUMBER		PISTON INSTALLATION (See figures ..... 2-5, 2-6, 2-7, and 2-8 for NHA)							REF		
-1	MS24665-300	96906	PIN, Cotter.....							2		PAOZZ
-2	MS17826-6	96906	NUT (AN320-8 Suitable substitute).....							2		PAOZZ
-3	AN960-616	88044	WASHER.....							4		PAOZZ
-4	MS20002C6	96906	WASHER.....							2		PAOZZ
-5	68485-6-020	56878	BOLT (LAC spec..... STSBG001A06D020)							2		XBFFZ
	VS2979A06D020	92215	BOLT (Alternate for 68485-6-020).....							2		PAOZZ
	BM3210-6A20D	85495	BOLT (Alternate for 68485-6-020).....							2		PAOZZ
	PBF1042A6D20	27624	BOLT (Alternate for 68485-6-020).....							2		PAOZZ
	AIC2264A06D020	06725	BOLT (Alternate for 68485-6-020).....							2		PAOZZ
	VAL23602-6DS20	06710	BOLT (Alternate for 68485-6-020).....							2		PAOZZ
-6	MS24665-302	96906	PIN, Cotter.....							2		PAOZZ
-7	MS17826-8	96906	NUT (AN320-8 Suitable substitute).....							2		PAOZZ
-8	AN960-816	88044	WASHER.....							4		PAOZZ
-9	MS20002C8	96906	WASHER.....							2		PAOZZ
-10	68485-8-024	56878	BOLT.....							2		PAOZZ
-11	4G13492-101A	98897	BUSHING.....							4		PAOZZ
-12	4G14551-101B	98897	ROLL POSITIONER (See T.O..... 4AA1-7-3) (see figure 2-1 for NHA)							2		PAFLD
-13	MS15001-1	96906	FITTING.....							3		PAOZZ
-14	4G13782-101A	98897	NUT, Round.....							1		PAOZZ
-15	4G13783-101A	98897	WASHER, Lock.....							1		PAOZZ
-16	4G13784-101A	98897	WASHER, Thrust.....							1		PAOZZ
-17	4G13700-101A	98897	WASHER, Thrust.....							1		PAFLD
-18	4G11439-107B	98897	ROLL PIN ASSEMBLY.....							1		PAFLD
	4G11439-113A	98897	ROLL PIN ASSEMBLY (preferred..... spare for 4G11439-107B)							1		PAFLD
	7729278	98897	ROLL PIN ASSEMBLY - PARTS KIT..... (7729278-90, -110, -130, -150, -170 kits are interchangeable and al- ternate for 4G11439-113A and 4G13402-101C and 4G13403-101C combined)							1		PAFLD
	7729278		ROLL PIN ASSEMBLY (Alternate for..... 4G11439-107B)							1		PAFLD
-18A	4G13402-101B	98897	GUDGEON SPACER (Inboard).....							1		PADZZ
	4G13402-101C	98897	GUDGEON SPACER (Inboard)..... (preferred alternate for 4G13402-101B)							1		PADZZ
-18B	4G13403-101B	98897	GUDGEON SPACER (Outboard).....							1		PADZZ
	4G13403-101C	98897	GUDGEON SPACER (Outboard)..... (preferred alternate for 4G13403-101B)							1		PADZZ
-19	MS15001-1	96906	FITTING.....							1		PAOZZ
-20	4G13544-103A	98897	BUSHING.....							1		PADZZ
-21	4G13407-103A	98897	BUSHING.....							4		PADZZ
-22	4G11439-109B	98897	ROLL PIN.....							1		PAFLD
-23	LS35196-1	98897	SEAL.....							1		PAFZZ
-24	78863	09455	RING, Thrust (LAC spec..... 4G94433-101A)							1		PAFZZ
-25	4G13499-101A	98897	RING, Threaded retainer.....							1		PAOZZ
-26	4G13503-101A	98897	WASHER, Lock.....							1		PAOZZ
-27	4G13502-101A	98897	SHIM, Upper bearing.....							1		PAFZZ
-28	4G13504-101A	98897	BEARING, Sleeve.....							1		PAOZZ
	4G9405-101B	98897	BEARING, Sleeve (preferred spare..... for 4G13504-101A)							1		PAOZZ
-29	4G13509-101A	98897	SHIM, Bearing.....							1		PAFZZ
-30	4G13507-101A	98897	SPACER, Snubber.....							1		PAOZZ
-31	4G13508-101A	98897	VALVE, Snubber.....							1		PAOZZ
-32	4G13506-101A	98897	SLEEVE, Lock.....							1		PAOZZ
-33	4G13505-101A	98897	RING, Lock.....							1		PAOZZ
-34	4G13435-101A	98897	SCREW, Nylon.....							4		PAOZZ
-35	4G13434-101A	98897	PIN, Lock.....							4		PAOZZ
-36	4G13433-101A	98897	RETAINER, Packing.....							1		PAOZZ
-37	S12561-451	97820	SEAL, Channel.....							1		PAOZZ



FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
2-10-38	AN6227-78	88044								1		PAOZZ
-38A	S34468P5	97820								1		PAOZZ
-39	7451FT2P3	72902								4		PAOZZ
-40	7451FT160A	72902								2		PAOZZ
-41	745A2MT2N	72902								6		PAOZZ
-42	745A2MT987	72902								3		PAOZZ
-43	DELETED											
-44	DELETED											
-45	4G94448-105A	98897								1		PAFDD
	4G94448-105B	98897								1		PAFDD
-46	4G53767-105A	98897								1		MOOZZ
-47	351-45100-312A	72902								1		PAFZZ
-48	DELETED											
-49	4G13703-101A	98897								1		PAOZZ
-50	4G13436-101A	98897								1		PAOZZ
-51	DELETED											
-52	4G13437-101B	98897								1		PAOZZ
	4G13437-105A	98897								1		PAOZZ
-53	4G14648-101A	98897								2		PAOZZ
-54	4G13686-101A	98897								4		PAOZZ
-55	4G13501-101A	98897								1		PAOZZ
-56	4G13496-103A	98897								1		PAOBZ
-57	4G13495-101A	98897								1		PAOZZ
-58	4G12432-101A	98897								1		PADLD
-59	4G13440-101A	98897								1		PAOZZ
	8341160-01	98747								1		PAOZZ
-60	4G12408-101A	98897								1		PADZZ
-61	4G13413-101A	98897								1		XA
-61A	8240768-01	98747								1		PADZZ
-61B	MS28775-125	96906								1		PADZZ
-62	7926445	98747								1		PAOLD
-63	MS28778-4	96906								1		PAOZZ
-64	MS28773-04	96906								1		PAOZZ
-65	1-03076C4	70195								1		PAOZZ
-66	G3714	03936								1		PAFZZ
	1000-38	24708								1		PAFZZ
-67	8631382-01	98747								1		PAOZZ
-68	MS28889-1	96906								1		PAOZZ
-69	MS28778-5	96906								1		PAOZZ
-70	MS28775-013	96906								2		PAOZZ
-71	MS28774-013	96906								4		PAOZZ
-72	4G13522-101A	98897								1		PAOZZ
	8121312-01	98747								1		PAOZZ
-73	4G13679-101A	98897								1		PAOZZ
-74	20261SL475	10989								1		PAOZZ
-75	MS28778-2	96906								1		PAOZZ
-76	AN814-26	88044								1		PAOZZ
-77	NAS509-12	80205								1		PAOZZ
-78	4G13521-101A	98897								1		PAOZZ
-79	MS28774-218	96906								2		PAOZZ
-80	AN6227-23	88044								2		PAOZZ
-81	MS28774-346	96906								2		PAOZZ
-82	AN6227-49	88044								1		PAOZZ
-83	4G13519-101A	98897								1		PAFZZ
-84	4G13520-101A	98897								1		PAOZZ
-85	4G13518-101A	98897								1		PADZZ
-86	MS28774-114	96906								2		PADZZ
-87	AN6227-12	88044								1		PADZZ
-88	MS28774-214	96906								2		PADZZ
-89	AN6227-19	88044								1		PADZZ
-90	4G13390-101A	98897								1		PAOZZ
-91	44C8MK2N	72902								4		PADZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
2-10-92	44C8MR2T	72902	.	.	.	.	.	.	.	4		PADZZ
.93	44C8MTE160A	72902	.	.	.	.	.	.	.	2		PADZZ
	744F8MTE-160-4780	72902	.	.	.	.	.	.	.	2		PAOZZ
			.	.	.	.	.	.	.			
.94	4G53767-101A	98897	.	.	.	.	.	.	.	3		MOOZZ
			.	.	.	.	.	.	.			
.95	4G13676-101A	98897	.	.	.	.	.	.	.	1		PADZZ
.96	4G13513-101A	98897	.	.	.	.	.	.	.	1		PADZZ
.97	4G13512-101A	98897	.	.	.	.	.	.	.	1		PADZZ
.98	4G13510-101A	98897	.	.	.	.	.	.	.	1		PADZZ
	8412565-01	98847	.	.	.	.	.	.	.	1		PADZZ
			.	.	.	.	.	.	.			
	8412565-03	98747	.	.	.	.	.	.	.	1		PADZZ
			.	.	.	.	.	.	.			
.99	4G13515-101A	98897	.	.	.	.	.	.	.	1		PADZZ
.100	4G13516-101A	98897	.	.	.	.	.	.	.	1		PADZZ
.101	AN6230-8	88044	.	.	.	.	.	.	.	2		PADZZ
	MS28775-230	96906	.	.	.	.	.	.	.	2		PADZZ
			.	.	.	.	.	.	.			
.102	MS28774-230	96906	.	.	.	.	.	.	.	4		PADZZ
.103	326FK2N	72902	.	.	.	.	.	.	.	4		PADZZ
.104	326FR2T	72902	.	.	.	.	.	.	.	4		PADZZ
.105	326FTE160A	72902	.	.	.	.	.	.	.	2		PADZZ
.105A	7326FTE-160-P5	72902	.	.	.	.	.	.	.	1		PADZZ
.105B	7326FTE-964-4780	72902	.	.	.	.	.	.	.	1		PADZZ
			.	.	.	.	.	.	.			
.106	4G53767-109A	98897	.	.	.	.	.	.	.	3		MDOZZ
			.	.	.	.	.	.	.			
.107	4G13514-101A	98897	.	.	.	.	.	.	.	1		PADZZ
.108	4G12409-101B	98897	.	.	.	.	.	.	.	1		PADDD
.109	4G13662-101A	98897	.	.	.	.	.	.	.	1		PADZZ
	4G19051-103A	98897	.	.	.	.	.	.	.	1		PADZZ
			.	.	.	.	.	.	.			
.110	4G12409-103A	98897	.	.	.	.	.	.	.	1		PADBZ
.111	4G13677-101A	98897	.	.	.	.	.	.	.	1		PADZZ
.112	4G11414-107A	98897	.	.	.	.	.	.	.	1		PADLD
	7926446-10	98747	.	.	.	.	.	.	.	1		PADLD
	7926446-30	98747	.	.	.	.	.	.	.	1		PADLD
			.	.	.	.	.	.	.			
	7926-446-50	98747	.	.	.	.	.	.	.	1		PADLD
			.	.	.	.	.	.	.			
.113	4G13491-103A	98897	.	.	.	.	.	.	.	1		PADZZ
	4G13491-105A	98897	.	.	.	.	.	.	.	1		PADZZ
			.	.	.	.	.	.	.			
.114	4G13490-117A	98897	.	.	.	.	.	.	.	1		PADZZ
			.	.	.	.	.	.	.			
	8020270-30	98747	.	.	.	.	.	.	.	1		PAFZZ
.115	4G14599-101A	98897	.	.	.	.	.	.	.	1		PADZZ
	7926422-01	98747	.	.	.	.	.	.	.	1		PADZZ
.116	ARP568-047	81343	.	.	.	.	.	.	.	1		PADZZ
.117	4G14604-101A	98897	.	.	.	.	.	.	.	4		PADZZ
.118	4G11414-109A	98897	.	.	.	.	.	.	.	1		PADLD



**Figure 2.11. Ballscrew Drive Housing Assembly**

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-11-	4G11416-101B	98897	BALLSCREW DRIVE HOUSING..... ASSEMBLY (See figures 2-5, 2-6, 2-7, and 2-8 for NHA)	REF		PAFFF
	4G11416-101C	98897	BALLSCREW DRIVE HOUSING..... ASSEMBLY (See figures 2-5, 2-6, 2-7, and 2-8 for NHA)	REF		PAFFF
-1	NAS1423-4	80205	NUT.....	1		PAOZZ
-2	4G13812-101A	98897	STUD (See figure 2-1 for NHA).....	REF		PAFZZ
-3	AN6H6A	88044	BOLT.....	4		PAOZZ
-4	AN960PD616L	88044	WASHER.....	4		PAOZZ
-5	4G13560-101A	98897	RETAINER, Gear.....	1		PAOZZ
-6	MS20364-918	96906	NUT.....	3		PAOZZ
-6A	MS15001-4		FITTING, Grease.....	2		PAOZZ
-7	AN960PD916	88044	WASHER.....	3		PAOZZ
-8	4G12423-101A	98897	PLATE ASSEMBLY, Upper.....	1		PAFFF
-9	MS124738	96906	INSERT.....	4		PAOZZ
-10	4G12423-103A	98897	PLATE, Upper.....	1		PAFFF
-11	4G13598-101A	98897	GEAR, Drive.....	1		PAOZZ
-12	4G13668-101A	98897	SPACER.....	1		PAFZZ
-13	4G13604-101A	98897	SPACER, Bearing race.....	2		PAFZZ
-14	4G13667-101A	98897	SPACER, Bearing.....	2		PAFZZ
-15	MS17130-7	96906	RACE.....	4		PAOZZ
	8742944-01	98747	RACE, (Preferred spare for..... MS17130-07)	4		PAOZZ
-16	DELETED					
-17	MS17131-30	96906	BEARING.....	4		PAOZZ
-18	4G13603-101A	98897	WASHER, Thrust.....	4		PAOZZ
-19	4G12435-101A	98897	SPROCKET ASSEMBLY, Drive.....	2		PAOZZ
-20	4G13601-101A	98897	SPROCKET.....	2		XA
-21	4G13670-101A	98897	KEY, Sprocket.....	4		PAFZZ
-22	4G13602-101A	98897	GEAR.....	2		XA
-23	4G13666-101A	98897	BOLT.....	3		PAOZZ
-24	4G13678-101A	98897	SHAFT, Threaded.....	1		PAFFF
-25	4G13665-103A	98897	SHAFT, Threaded.....	2		PAOZZ
	7829287-01	98747	SHAFT, Threaded, alt.....	2		PAOZZ
-26	209SZZ	38443	BEARING.....	2		PAOZZ
-27	4G13558-101A	98897	PLATE ASSEMBLY, Lower housing.....	2		PAFZZ
-28	MS124738	96906	INSERT.....	4		PAOZZ
-29	MS124736	96906	INSERT.....	3		PAOZZ
-30	4G13558-101A	98897	PLATE, Lower housing.....	1		XA

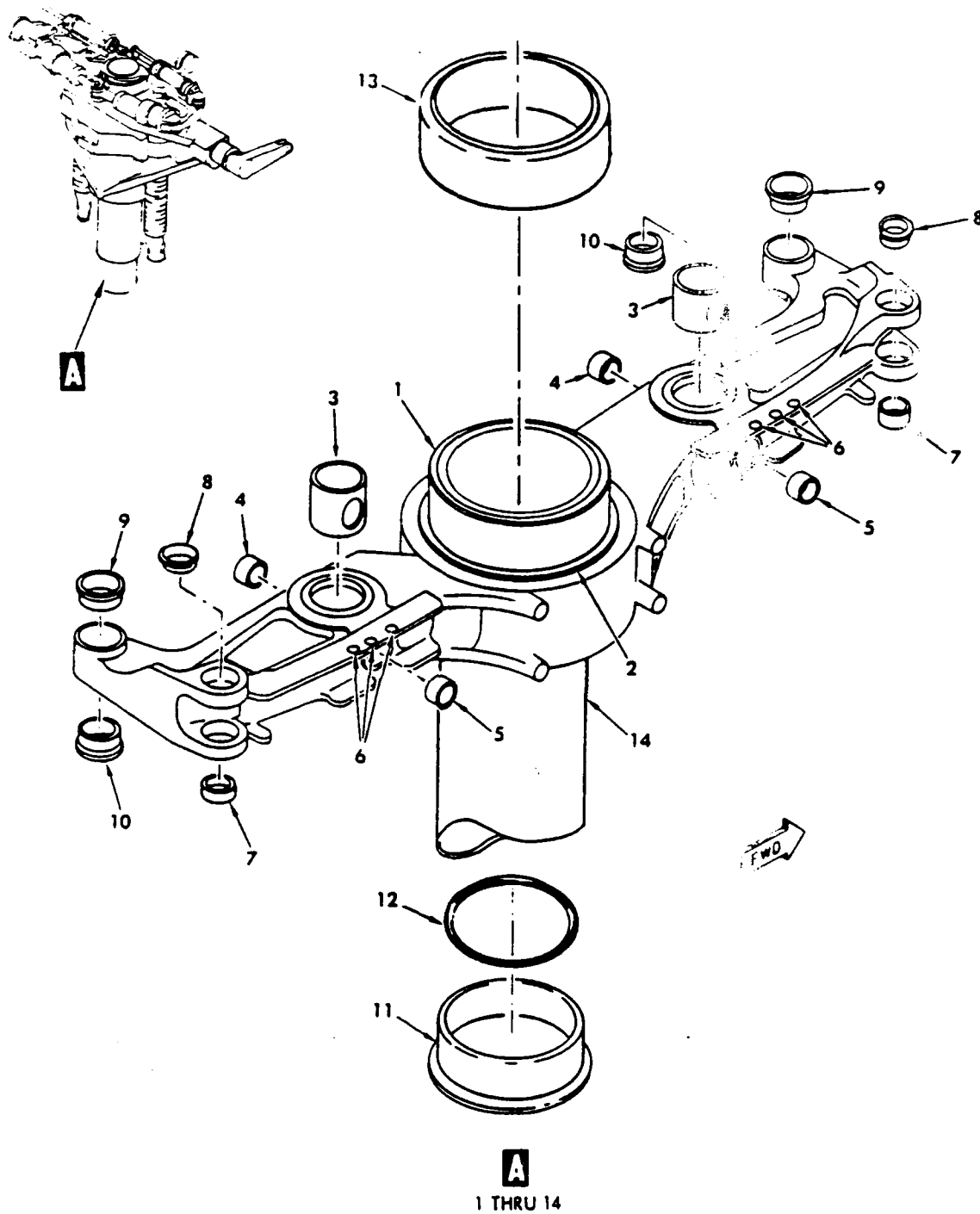
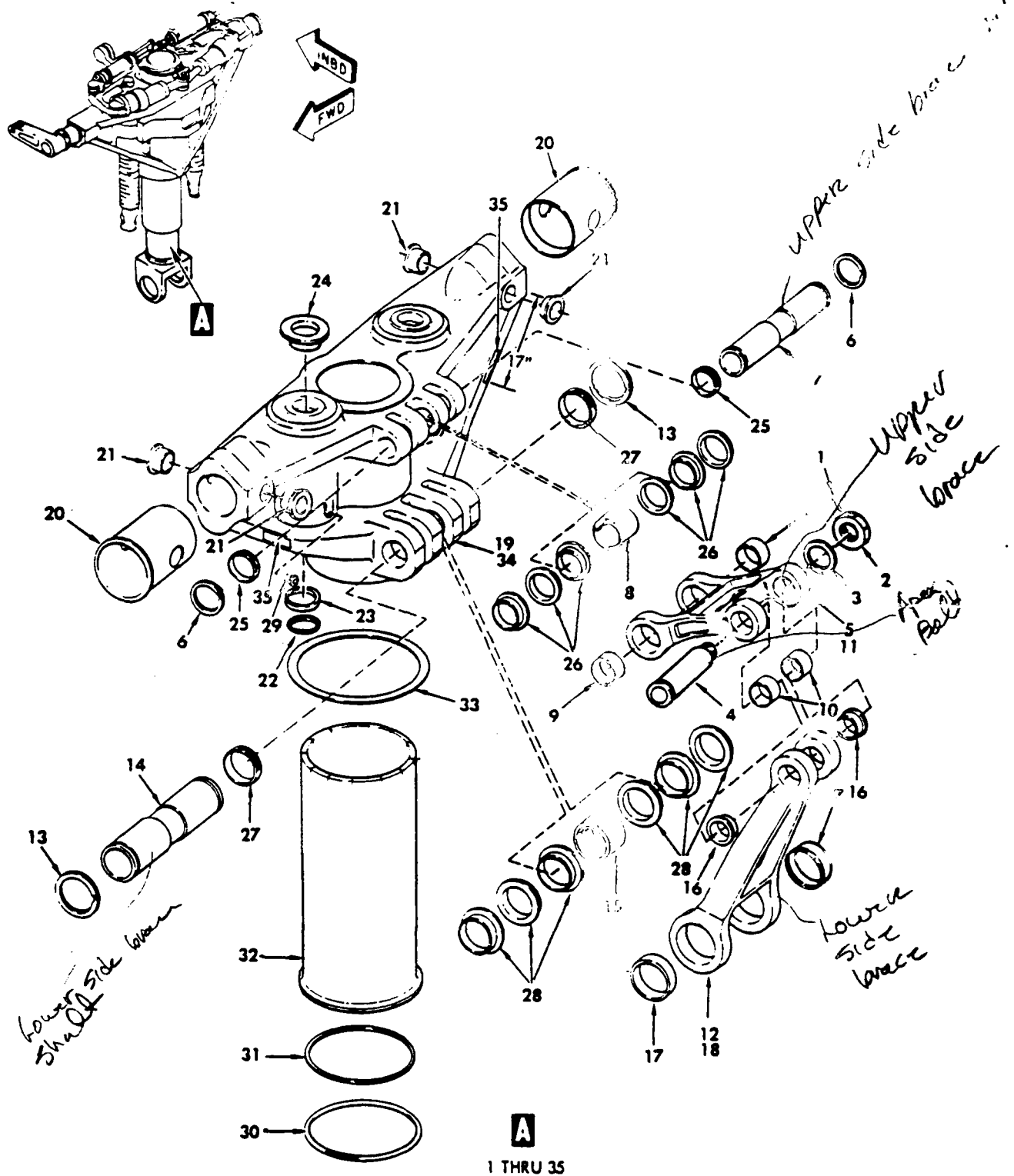


Figure 2-12. Outer Cylinder Assembly

FIG & INDEX NO	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	TS R Y	USABLE ON CODE	SMP CODE
2-12-	4G11415-107A	98897	CYLINDER ASSEMBLY, OUTER (See figures 2-5, 2-6, 2-7, and 2-8 for NHA)	FF		PAFDD
	4G11415-107C	98897	CYLINDER ASSEMBLY, OUTER (See figures 2-5, 2-6, 2-7, and 2-8 for NHA)	FF		PAFDD
-1	4G13611-103A	98897	BEARING, Sleeve	1		PADZZ
	7729790-01	98747	BEARING, Sleeve, repair	1		PADZZ
-2	4G13612-101A	98897	BEARING, Thrust	1		PADZZ
	4G13612-103A	98897	BEARING (Preferred spare for -101A)	1		PADZZ
-3	4G13588-105A	98897	BUSHING, Sleeve	2		PADZZ
	4G14609-101A	98897	BUSHING, Flanged Repair	2		PADZZ
-4	4G13591-103A	98897	BUSHING, Sleeve	2		PADZZ
	4G13591-105A	98897	BUSHING (Preferred spare for -103A)	2		PADZZ
-5	4G13672-103A	98897	BUSHING, SLEEVE	2		PADZZ
	4G13672-105A	98897	BUSHING (Preferred spare for -103A)	2		PADZZ
-6	4G13673-103A	98897	BUSHING, Flanged	6		PADZZ
	4G13673-105A	98897	BUSHING (Preferred spare for -103A)	6		PADZZ
-7	4G13385-103A	98897	BUSHING, Sleeve	2		PADZZ
	4G13385-105A	98897	BUSHING (Preferred spare for -103A)	2		PADZZ
-8	4G13382-103A	98897	BEARING, Flanged	2		PADZZ
	4G13382-105A	98897	BUSHING (Preferred spare for -103A)	2		PADZZ
	4G13382-109A	98897	BUSHING (Preferred spare for 4G13382-105A)	2		PADZZ
-9	4G13675-103A	98897	BEARING, Flanged	2		PADZZ
	4G13675-109A	98897	BUSHING, (Preferred spare for -101A and -103A)	2		PADZZ
-10	4G13675-107A	98897	BEARING, Flanged	2		PADZZ
	4G13675-109A	98897	BUSHING (Preferred spare for -105A and -107A)	2		PADZZ
-11	4G14598-101A	98897	BUSHING, Special ID repair	1		PADZZ
-12	2-171S604-70	38597	PACKING (Used with repair 4G14598-101A)	1		PADZZ
-13	4G14597-101A	98897	BUSHING, Special OD Repair	1		PADZZ
-14	4G11415-109A	98897	CYLINDER, Outer	1		PADZZ



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Figure 2-13. Yoke and Side Brace Assembly.

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SME CODE
2-13-	NO NUMBER		YOKE AND SIDE BRACE ASSEMBLY..... (See figures 2-5, 2-6, 2-7, and 2-8 for NHA)	REF		XA
-1	MS24665-439	96906	PIN, Cotter.....	1		PAOZZ
-2	4G13525-101A	98897	NUTS.....	1		PAOZZ
-3	4G13756-101A	98897	WASHER.....	1		PAOZZ
-4	4G13537-101A	98897	BOLT, Apex.....	1		PAFDD
-5	4G11436-107A	98897	ARM ASSEMBLY, Upper side brace.....	1		PAFLD
-6	RS318CD	80756	RING, Retaining (AP).....	2		PAFZZ
-7	4G13538-101A	98897	SHAFT, Upper (AP).....	1		PAFDD
-8	4G13540-101A	98897	RING, Upper split retainer (AP).....	1		PAFZZ
-9	4G13533-103A	98897	BUSHING, Sleeve.....	2		PADZZ
	4G13533-105A	98897	BUSHING (Preferred spare for..... -103A)	2		PADZZ
	8412410-01	98747	BUSHING, Flanged (single face..... repair)	2		PADZZ
	8412410-03	98747	BUSHING, Flanged (dual face..... repair)	4		PADZZ
-10	4G13534-103A	98897	BUSHING, Flanged.....			PADZZ
	4G13534-105A	98897	BUSHING (Preferred spare for..... -103A)	2		PADZZ
-11	4G11436-109A	98897	ARM, Upper side brace.....	1		XA
-12	4G11435-101A	98897	ARM ASSEMBLY, Lower side brace.....	1		PAFLD
-13	RS450CD	80756	RING, Retaining (AP).....	2		PAFZZ
-14	4G13539-101A	98897	SHAFT, Lower (AP).....	2		PAFDD
-15	4G13541-101A	98897	RING, Lower split retainer (AP).....	1		PAFZZ
-16	4G13536-103A	98897	BUSHING, Flanged.....	2		PADZZ
	4G13536-105A	98897	BUSHING (Preferred spare for..... -103A)	4		PADZZ
-17	4G13535-103A	98897	BUSHING, Sleeve.....	2		PADZZ
	4G13535-105A	98897	BUSHING (Preferred spare for..... -103A)	2		PADZZ
	8412410-05	98747	BUSHING, Flanged (single face..... repair)	2		PADZZ
	8412410-07	98747	BUSHING, Flanged (dual face..... repair)	4		PADZZ
-18	4G11435-103A	98897	ARM, Lower side brace.....			XA
-19	4G11430-113B	98897	YOKE ASSEMBLY.....	1		PAULD
	4G11430-119A	98897	YOKE ASSEMBLY (Preferred spare..... for 4G11430-113B)	1		PAULD
-20	4G13595-103A	98897	BUSHING.....	2		PADZZ
	4G13595-105A	98897	BUSHING (Preferred spare for..... -103A)	2		PADZZ
-21	4G13597-103A	98897	BUSHING, Flanged.....	4		PADZZ
	4G13597-105A	98897	BUSHING (Preferred spare for..... -103A)	4		PADZZ
-22	4G13348-101A	98897	RETAINER.....	1		PAFZZ
-23	4G13697-101A	98897	WASHER.....	1		PAFZZ
-24	4G13762-103A	98897	BUSHING, Flanged.....	2		PADZZ
	4G19063-101A	98897	BUSHING ASSEMBLY (Preferred..... spare for 4N13762-103A)	2		PADZZ
	4G19063-107A	98897	BUSHING (Preferred spare for..... -101A)	2		PADZZ
-25	4G13649-105A	98897	BUSHING, Sleeve.....	2		PADZZ
	4G13649-107A	98897	BUSHING (Preferred spare for..... -105A)	2		PADZZ
-26	4G13592-103A	98897	BUSHING, Flanged.....	6		PADZZ
	4G13592-107A	98897	BUSHING (Preferred spare for..... -103A)	6		PADZZ
-27	4G13650-105A	98897	BUSHING, Sleeve.....	2		PADZZ
	4G13650-107A	98897	BUSHING (Preferred spare for..... -105A)	2		PADZZ
-28	4G13593-103A	98897	BUSHING, Flanged.....	6		PADZZ
	4G13593-107A	98897	BUSHING (Preferred spare for..... -103A)	6		PADZZ
-29	4G13729-103A	98897	BUSHING, Flanged.....	4		PADZZ



FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PFR ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
2-13-29	4G13729-105A	98897	.	.	.	BUSHING (Preferred spare for .....				4		PADZZ
						.101A)						
.30	4G13763-101A	98897	.	.	.	SCRAPER, Ring (Ref.....				1		PAFFF
						MS28776-70)						
.31	MS29513-279	96906	.	.	.	PACKING.....				1		PAOZZ
.32	90725	09455	.	.	.	BEARING (Ref 4G94449-101A).....				1		PADZZ
	07-311-200-891E-001	09455	.	.	.	BEARING (Preferred spare for .....				1		PADZZ
						90725)						
.33	4G13695-101A	98897	.	.	.	WASHER, Thrust.....				1		PADZZ
.34	4G11430-115A	98897	.	.	.	YOKE.....				1		XA
.35	4G14368-101A	98897	.	.	.	CHAFE GUARD (Make from STM .....				AR		PAOZZ
						23-603 Class 2, Grade 80)						

# SECTION NUMERICAL

PART NUMBER	FIG & INDEX NO.	PART NUMBER	INDEX	PART NUMBER	FIG & INDEX NO.
AB-246-000	2-5-381		4-15	AN6227	2-10-80
	2-6-381		4-32	AN6227	2-10-8
	2-7-381		4-53	AN6227	2-10
	2-8-381		4-78	AN6230	2-10
AE12108-002	2-2-15C		4-81	AN6289	2-1-10
	2-3-15C		5-6		2-4-39
AE702976-2	2-2-15		5-41		
	2-3-15		5-57	AN6289	2-1-10
AE702984-2	2-2-16		5-95		2-5-10
	2-3-16				2-6-2188
AE94117G	2-2-15B	AN3066-8	5-121		2-7-222V
	2-3-15B		5-121		2-8-210
AIC2264A06D020	2-10-5		5-121	AN6289	2-1-10
AN23-22	2-5-76		5-121		2-5-10
	2-6-76		5-14-17A		2-6-207
	2-7-76		5-14-35		2-7-207
	2-8-76		5-15-35G		2-8-207
AN23-23	2-5-76		5-46	AN735	2-5-10
	2-6-76		5-62		2-5-10
	2-7-76		5-91		2-6-10
	2-8-76	AN320-10	5-100		2-6-10
AN3062-4	2-15-94		5-100		2-7-100
			5-100		2-7-129A
AN3062-6	2-14-34		5-100		2-8-128A
	2-15-59	AN320-3	5-73		2-8-129
AN3062-8	2-14-37		5-73	AN74	2-14-63
	2-15-63		5-73	AN74	2-6-280
AN3063-6	2-5-120		5-73		2-8-280
	2-6-120	AN320-4	2-4-55		2-14-50
	2-7-120		5-212		2-15-73
	2-8-120		5-212		2-15-77
	2-14-82		5-212	AN8-2	2-9-20
	2-15-98		5-212	AN8-2	2-10-73
AN3063-8	2-5-122	AN320-6	5-2738	AN8-2	2-1-83
	2-6-122		5-2738	AN9	2-1-77
	2-7-122	AN355-4	5-142	AN9	2-1-79
	2-8-122	AN4H10A	5-68		2-1-92
AN3064-12	2-14-39		5-68		2-1-96
	2-14-85		5-68		2-1-98
AN3064-6	2-14-14		2-8-68		2-1-102
	2-14-54	AN5-66A	2-5-346		2-1-107
	2-14-79		2-5-346		2-1-111
	2-15-7		2-7-346		2-1-113
	2-15-42		2-8-346		2-1-116
	2-15-60	AN502-10-16	2-4-57		2-1-124
	2-15-96		2-5-116		2-5-38
AN3064-8	2-14-17B		2-6-116		2-6-38
	2-14-36		2-7-116		2-7-38
	2-15-35G		2-8-116		2-8-10
	2-15-47	AN502-416-14	5-1-28	AN92	2-5
	2-15-61				2-5-220
	2-15-92	AN502-416-16	2-6-387		2-6-216Q
AN3066-12	2-14-38		2-8-387		2-6-216Q
	2-14-84	AN502-416-8	2-1-24		2-6-216Q
AN3066-4	2-15-93		2-1-24A		2-6-216Q
AN3066-6	2-5-119		2-1-27		2-7
	2-6-119	AN6H6A	2-1-3		2-7-2
	2-7-119	AN6227-12	2-10-87		2-8-216
	2-8-119	AN6227-19	2-10-89		2-8-2

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
AN924-8D	2-8-218K	AN960-516	2-5-249		2-8-126
AN939-8	2-4-24		2-6-249	AN960D10L	2-8-130A
AN960-10	2-5-75		2-7-249		2-2-27
	2-6-75		2-8-249		2-2-55
	2-6-349A		2-15-90		2-3-27
	2-7-75	AN960-616	2-5-201		2-3-54
	2-8-75		2-5-364	AN960D1216L	2-14-80
AN960-10L	2-8-349A		2-6-201		2-14-83
	2-5-189		2-6-364	AN960D416	2-15-97
	2-6-189		2-7-201		2-1-56
	2-7-189		2-7-364		2-1-57A
AN960-1016	2-8-189		2-8-201		2-1-67
	2-5-101		2-8-364		2-5-41
	2-6-101		2-10-3		2-5-50
	2-7-101	AN960-816	2-5-185		2-5-52
AN960-1616	2-8-101		2-5-344		2-5-56
	2-5-166		2-6-185		2-6-41
	2-6-166		2-6-344		2-6-50
	2-7-166		2-7-185		2-6-52
	2-8-166		2-7-344		2-6-56
AN960-2116	2-9-23		2-8-185		2-7-41
AN960-416	2-1-21		2-8-344		2-7-50
	2-1-47		2-9-19		2-7-52
	2-5-197		2-10-8		2-7-56
	2-5-213	AN960-916L	2-2-47		2-8-41
	2-5-216		2-3-37		2-8-50
	2-5-241		2-3-39		2-8-52
	2-5-256		2-4-53	AN960D416L	2-8-56
	2-5-260	AN960CH16L	2-1-39	AN960D516	2-1-57
	2-5-286	AN960C10L	2-5-148		2-4-34
	2-5-290		2-5-153		2-5-61
	2-5-338		2-5-221C		2-6-61
	2-6-197		2-6-148		2-7-61
	2-6-213		2-6-153		2-8-61
	2-6-217N		2-6-221	AN960D6	2-5-130B
	2-6-217Q		2-7-148		2-5-130D
	2-6-221		2-7-153		2-6-130B
	2-6-241		2-7-221C		2-6-130D
	2-6-256		2-8-148		2-7-130B
	2-6-260		2-8-153		2-7-130D
	2-6-286		2-8-221		2-8-130B
	2-6-290	AN960C3616	2-5-3		2-8-130D
	2-6-338		2-5-8	AN960D616	2-1-63
	2-7-197		2-6-3		2-5-35
	2-7-213		2-6-8		2-6-35
	2-7-216		2-7-3		2-7-35
	2-7-241		2-7-8		2-8-35
	2-7-256		2-8-3	AN960D616L	2-1-60
	2-7-260		2-8-8		2-5-36
	2-7-286		2-1-32		2-6-36
	2-7-290	AN960C416L	2-5-142		2-7-36
	2-7-338		2-6-142		2-8-36
	2-8-197		2-7-142	AN960D716	2-2-25
	2-8-213		2-8-142		2-2-26
	2-8-217N	AN960C616L	2-1-33		2-2-52
	2-8-217Q		2-5-143		2-3-25
	2-8-221		2-6-143		2-3-26
	2-8-241		2-7-143		2-3-50
	2-8-256		2-8-143	AN960PD10L	2-5-79
	2-8-260		2-2-23		2-6-79
	2-8-286	AN960D10	2-3-23		2-6-278
	2-8-290		2-5-126		2-7-79
	2-8-338		2-5-130A		2-8-79
	2-14-104		2-6-126		2-8-278
	2-15-90		2-6-130A	AN960PD1216	2-5-222F
	2-15-109		2-7-126		2-6-216P
960-416L	2-5-218		2-7-130A		
	2-7-218				

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
AN960PD1216	2-6-217J 2-7-222F 2-8-216P 2-8-217J		2-6-375 2-7-375 2-8-375 2-10-46 2-10-94	GA7420F0808 GA7424F0404 GA7424F0606	2-4-25 2-2-21 2-2-17
AN960PD4016	2-5-359 2-6-359 2-7-359 2-8-359	CF206		GA7433F0404 GA7433F0606 GA7442F060804 GA7443F0404 GA7443F0606 GA7444F0404 GA7444F0604 GA7444F0606 GA7444F0808 GA7461D0810	2-2-25 2-2-2C 2-4-11 2-2-40 2-2-2A 2-2-26 2-2-37 2-2-2 2-4-7 2-5-261G 2-6-261G 2-7-261G 2-8-261G
AN960PD416	2-5-69 2-6-69 2-7-69 2-8-69	DLG112F0404 DLG112F0606 DLG116F0404 DLG116F0606 DLG211F040404 DLG211F060604 DLG211F080804	2-2-25 2-2-2C 2-2-21 2-2-17 2-2-38 2-1-126 2-4-8		
AN960PD416L	2-5-237 2-6-237 2-7-237 2-8-237	DLG224F060804 DLG231F040604 DLG312F0404 DLG312F0606 DLG315F0404 DLG315F0604 DLG315F0606 DLG315F0808 DLG317F0808 DLG803F04	2-4-11 2-4-26 2-2-40 2-2-2A 2-2-26 2-2-37 2-2-2 2-4-7 2-4-25 2-2-25	GM515200-1	2-1-37 2-5-149 2-6-149 2-7-149 2-8-149 2-9-19
AN960PD616L AN960PD716	2-11-4 2-1-80 2-1-99 2-1-125	DLG803F06 DLG803F08 DREFS3	2-2-2 2-4-6 2-5-80 2-6-80 2-7-80 2-8-80	G3714	2-5-266 2-6-266 2-7-266 2-8-266 2-10-66 2-5-200 2-6-200 2-7-200 2-8-200
AN960PD816	2-5-204 2-6-204 2-7-204 2-8-204	ER112-0404 ER112-0606 ER116-0404 ER116-0606 ER211-040404 ER211-080804 ER211F060604	2-2-2 2-4-6 2-5-80 2-6-80 2-7-80 2-8-80 2-2-25 2-2-2C 2-2-21 2-2-17 2-2-38 2-4-8 2-1-126	H29649-6	2-9-3 2-10-28 2-5-354A 3-6-354A 2-7-354A 2-8-354A 2-5-354B 2-6-354B 2-7-354B 3-8-354B
AN960PD916 AN970-3	2-11-7 2-2-6 2-3-6	ER224-060804 ER231-040604 ER2333J06 ER2833J06	2-4-11 2-4-26 2-2-58 2-2-31 2-3-31 2-3-57 2-5-215S 2-6-222 2-7-215S 2-8-215Z	KPSE65057-392	2-5-87 2-6-87 2-7-87 2-8-87 2-9-2 2-3-62
AN970-4	2-1-45 2-5-336 2-6-336 2-7-336 2-8-336			KPSE65057-392W	2-14-40 2-14-86 2-15-67 2-15-99 2-9-1 2-10-23 2-1-61 2-5-59 2-6-59 2-7-59 2-8-59
ARP568-047 AS1008J1008	2-10-116 2-5-215C 2-5-222V 2-7-215C 2-7-222V	ER312-0404 ER312-0606 ER315-0404 ER315-0604 ER315-0606 ER315-0808	2-2-40 2-2-2A 2-2-26 2-2-37 2-2-2 2-4-7	LC059G12MW	2-1-12 2-5-268 2-6-268 2-7-268 2-8-268 2-14-41 2-14-101
AS1009J100410 AS1010J0810	2-1-135 2-6-215N 2-8-215N	ER317-0808 E50CL	2-4-25 2-5-341 2-6-341 2-7-341 2-8-341 2-5-80 2-6-80 2-7-80 2-8-80	LS331-22	
BM3210-6A20D B15576-10	2-1C-5 2-5-359 2-6-359 2-7-359 2-8-359	FR-3DE	2-5-80 2-6-80 2-7-80 2-8-80	LS3502303S10 LS3502303S12	
B15576-12	2-5-356 2-6-356 2-7-356 2-8-356				
B15576-13R	2-5-360 2-6-360 2-7-360 2-8-360				
B15576B	2-5-381 2-6-381 2-7-381 2-8-381				
B7374B	2-5-384 2-6-384 2-7-384 2-8-384				
B7401B	2-5-383 2-6-383 2-7-383 2-8-383				
B7402B	2-5-375				

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
LS5918TB230B	2-14-42	LS607-40	2-15-4	MS21042-06	2-14-74
	2-14-100		2-15-51		2-14-76
LS5918TB230C	2-15-56B	LS607-6	2-14-63		2-14-91
	2-15-68	LS881-13	2-2-10		2-15-65
LS5918TB230D	2-15-56C		2-3-10		2-15-100
	2-15-69	LS881-22	2-2-34		2-4-44
			2-2-63		2-5-65
LS5935A333A	2-14-99		2-3-34		2-5-128A
LS5935A334A	2-15-56A	MS1-042-04	2-14-76		2-5-129A
LS5935A335A	2-14-88A	MS124736	2-11-29		2-5-130B
LS5935A336A	2-15-104	MS124738	2-11-9	MS21042-08	2-5-130D
LS5935J623A	2-14-24C		2-11-28		2-6-65
	2-15-35L	MS15001-1	2-9-8		2-6-128A
LS5935J624A	2-14-24		2-10-13		2-6-129A
	2-15-35K		2-10-19		2-6-130B
LS5935P623B	2-14-24B	MS15001-4	2-5-183		2-6-130D
	2-15-35N		2-5-322		2-7-65
LS5935P624A	2-14-24A		2-6-183		2-7-128A
	2-15-35M		2-6-322		2-7-129A
LS5935TB228A	2-15-102		2-7-183		2-7-130B
LS5935TB228B	2-15-103		2-7-322	MS21042-3	2-7-130D
			2-8-183		2-8-65
LS5935TB229A	2-14-88		2-8-322		2-8-128A
LS5935TB231A	2-14-87		2-11-6A		2-8-129A
LS5964R24-0122	2-1-55	MS16625-1137	2-5-177		2-8-130B
	2-5-47		2-6-177		2-8-130D
	2-6-47		2-7-177		2-14-90
	2-7-47		2-8-177		2-15-8
	2-8-47				2-15-105
LS5984D3L	2-3-2E	MS17130-7	2-11-15		2-1-39
LS5984S3M	2-1-86	MS17131-30	2-11-17		2-1-85
	2-1-119	MS17826-3	2-5-78		2-2-2D
	2-1-122		2-6-78		2-2-19
	2-6-215S		2-6-277		2-2-23
	2-6-215X		2-7-78		2-2-27
	2-6-215Y		2-8-78		2-2-34
	2-8-215S		2-8-277		2-2-39
	2-8-215U	MS17826-6	2-10-2		2-2-50
	2-8-215V	MS17826-8	2-9-18		2-2-55
LS5984S4M	2-5-92		2-10-7		2-2-63
	2-5-224	MS19060-26	2-5-275		2-3-2E
	2-5-255		2-6-275		2-3-19
	2-5-259		2-7-275		2-3-23
	2-6-92		2-8-275		2-3-27
	2-6-224	MS20002-10	2-2-2		2-3-34
	2-6-255		2-2-55		2-3-43
	2-6-259		2-3-2		2-3-54
	2-7-92	MS20002C6	2-10-4		2-3-62
	2-7-224	MS20002C8	2-10-9		2-3-66
	2-7-255	MS20002C9	2-2-15		2-4-49
	2-7-259		2-3-15		2-4-63
	2-8-92				2-5-124
	2-8-224	MS20292-3C15	2-5-46		2-5-130A
	2-8-255	MS20364-918	2-11-6		2-5-147
	2-8-259	MS20392-2C13	2-1-49		2-5-152
LS598453M	2-6-217P		2-5-31		2-5-227
	2-6-218M		2-6-31		2-5-221B
	2-8-217P		2-7-31		2-5-369
	2-8-218M		2-8-31		2-5-387
LS5987-10-56	2-14-26A	MS20392-3C15	2-1-51		2-6-124
	2-15-33		2-5-46		2-6-130A
	2-15-38		2-6-46		2-6-147
LS607-11	2-5-74		2-7-46		2-6-152
	2-6-74		2-8-46		2-6-215S
	2-7-74	MS21 919WDG11	2-2-27		2-6-215X
	2-8-74	MS210-42-3	2-5-277		2-6-215Y
LS607-24	2-14-63		2-7-277		2-6-217R
		MS21042-04	2-14-30		2-6-218N

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
MS21042-3	2-6-221L	MS21042-5	2-1-66	MS21042-6	2-1-33
	2-6-280A		2-5-40		2-5-60
	2-6-280E		2-5-49		2-5-248
	2-6-349		2-5-51		2-5-345
	2-6-369		2-5-55		2-6-4
	2-7-124		2-5-86		2-6-248
	2-7-130A		2-5-158		2-6-345
	2-7-147		2-5-196		2-7-60
	2-7-152		2-5-254		2-7-243
	2-7-221B		2-5-258		2-7-345
	2-7-227		2-5-285		2-8-60
	2-7-369		2-5-289		2-8-248
	2-7-387		2-5-335		2-8-345
	2-8-124		2-5-390		2-15-90
	2-8-130A		2-6-40		2-1-79
	2-8-147		2-6-49		2-5-84
	2-8-152		2-6-51		2-5-273B
	2-8-215S		2-6-55		2-5-363
	2-8-215U		2-6-86		2-6-34
	2-8-215V		2-6-158		2-6-363
	2-8-217R		2-6-196		2-7-34
	2-8-218N		2-6-254		2-5-273B
	2-8-221L		2-6-258		2-7-33
	2-8-280A		2-6-285		2-8-34
	2-8-280E		2-6-289	MS21043-3	2-8-363
	2-8-349		2-6-335		2-1-18
	2-8-369		2-6-390		2-14-47
	2-14-3A	MS21042-5	2-7-40	MS21083D5	2-5-11
	2-14-7		2-7-49		2-6-111
	2-14-13		2-7-51		2-7-111
	2-14-188		2-7-55	MS21083D8	2-8-111
	2-14-22		2-7-86		2-5-1
	2-14-24H		2-7-158		2-6-105
	2-14-26		2-7-196	MS21209F1-15	2-7-105
	2-14-27C		2-7-254		2-8-105
	2-14-29		2-7-258		2-5-106
	2-14-47A		2-7-285	MS21241-08A012	2-6-136
	2-14-47C		2-7-289		2-7-136
	2-14-50		2-7-335		2-5-115
	2-14-55		2-7-390	MS21241-12A010	2-6-135
	2-14-58		2-8-40		2-7-135
	2-14-61		2-8-49		2-8-135
	2-14-63		2-8-51	MS21241-12A012	2-5-11
	2-14-70		2-8-55		2-5-109
	2-14-98		2-8-86		2-5-114
	2-14-105		2-8-158		2-6-97
	2-15-5A		2-8-196		2-6-109
	2-15-15		2-8-254		2-6-114
	2-15-20		2-8-258		2-7-97
	2-15-25		2-8-285		2-7-109
	2-15-28		2-8-289		2-7-114
	2-15-35B		2-8-335		2-8-97
	2-15-36C		2-8-390		2-8-109
	2-15-36E		2-2-11		2-8-114
	2-15-36F		2-3-11	MS21241-12A012	2-5-134
	2-15-39		2-4-33		2-6-134
	2-15-44		2-4-55		2-7-134
	2-15-51		2-5-60		2-8-134
MS21042-4	2-15-66		2-5-248	MS21250-07100	2-9-6
	2-15-73		2-5-345		2-1-53
	2-15-78		2-6-60	MS21251B5S	2-5-28
	2-15-83		2-6-248		2-6-28
	2-15-88		2-6-345	MS21252-5LS	2-7-28
	2-1-20		2-7-60		2-8-28
	2-1-43		2-7-248		2-1-52
	2-1-56		2-7-345		2-5-45
	2-1-57		2-2-11		2-6-45
	2-1-57A		2-3-11		

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
MS21252-5LS	2-7-45		2-4-47		2-15-82
	2-8-45		2-3-2D		2-15-88
MS21256-1	2-1-54	MS21919WDG10	2-6-215X	MS21919WDG10	2-2-15
	2-5-29		2-6-218D		2-3-15
	2-6-29		2-8-215U		2-6-215Y
	2-7-29		2-8-218D		2-6-217G
MS21295-50	2-8-29		2-14-18A		2-8-215V
	2-1-47		2-14-21		2-8-217G
	2-5-337		2-14-97		2-14-3A
	2-6-337		2-15-27		2-14-11
	2-7-337		2-15-32		2-14-24F
	2-8-337		2-15-37		2-14-27C
MS21803D20	2-9-22		2-15-49		2-14-47A
MS21902-J4	2-1-91		2-15-87		2-14-47C
	2-1-95	MS21919WDG11	2-2-55		2-14-47D
	2-1-110		2-3-27		2-14-68
MS21902-6	2-1-29		2-3-54		2-14-98
	2-5-155		2-14-1		2-15-5
	2-6-155		2-14-70		2-15-24
	2-7-155		2-15-14		2-15-35
	2-8-155		2-15-26		2-15-36A
			2-15-71		2-15-36C
MS21902J4	2-1-78		2-15-81		2-15-36D
	2-5-209	MS21919WDG12	2-15-30		2-15-36E
	2-5-392	MS21919WDG13	2-15-1		2-15-36F
	2-5-222J	MS21919WDG14	2-14-7		2-14-23
	2-6-209		2-14-25	MS21919WDG15	2-15-37
	2-6-216K		2-15-3	MS21919W111	2-2-2E
	2-6-392		2-15-19	MS21922-6	2-1-84
	2-7-209		2-15-50	MS21924J10	2-1-112
	2-7-392	MS21919WDG4	2-1-87	MS21924J4	2-1-114
	2-7-222J		2-5-220		2-5-389B
	2-8-209		2-6-221B		2-6-389E
	2-8-216K		2-7-220		2-7-389B
MS21902J8	2-8-392		2-8-221B		2-8-389B
	2-5-222S		2-14-18B	MS21924J8	2-5-172
	2-6-216A		2-14-27A		2-5-222C
	2-6-216F		2-14-57		2-6-172
	2-6-217D		2-15-39		2-6-216L
	2-6-217T	MS21919WDG6	2-2-2D		2-6-217
	2-6-219		2-3-2E		2-6-218L
	2-7-222S		2-5-278		2-6-220
	2-8-216A		2-7-278		2-7-172
	2-8-216F		2-14-3		2-7-222C
	2-8-217D		2-14-13		2-8-172
	2-8-217T		2-14-47B		2-8-216B
	2-8-219		2-14-60		2-8-217
MS21907-J6	2-3-2B		2-14-65		2-8-218L
MS21907-6	2-3-3		2-14-69		2-8-220
MS21907J4	2-1-81		2-15-5A	MS23778-4	2-1-94
MS21908-4	2-4-37		2-15-12		2-2-54
MS21908J10	2-6-218C		2-15-83		2-3-53
	2-8-218C	MS21919WDG7	2-6-280C	MS23778-6	2-2-62
MS21912J4	2-1-140		2-8-280C		2-3-61
MS21916J10-8	2-5-215B		2-14-2	MS24255-20S	2-16-38
	2-7-215B		2-14-6		2-16-59
MS21919DG4	2-2-23		2-14-10		
	2-2-39		2-14-27B		
	2-3-23		2-14-49	MS24266R10B50N	2-5-140
	2-3-43		2-14-58		2-6-140
	2-3-66		2-14-61		2-7-140
	2-5-387		2-14-67		2-8-140
	2-7-387		2-15-2		2-15-48
			2-15-10	MS24665-132	2-1-50
MS21919DG6	2-4-46		2-15-18		2-5-30
MS21919DG8	2-2-19		2-15-25		2-5-44
	2-2-50		2-15-72		2-6-30
	2-3-19		2-15-76		2-6-44

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
MS24665-132	2-7-30 2-7-44 2-8-30 2-8-44	MS25181-2	2-8-123 2-16-19	MS28773-10	2-10-64 2-1-133 2-5-222V 2-5-222W 2-6-218A 2-7-222V 2-7-222W 2-8-218A
MS24665-134	2-1-141	MS27183-12	2-5-347 2-6-347 2-7-347		
MS24665-153	2-4-51 2-4-51A 2-5-77 2-5-211 2-5-276 2-6-77 2-6-211 2-6-276 2-7-77 2-7-211 2-7-276 2-8-77 2-8-211 2-8-276	MS27186-1	2-16-5 2-16-13 2-16-21 2-16-30 2-16-40 2-16-50 2-16-62 2-16-74 2-1-38 2-14-106	MS28774-013 MS28774-114 MS28774-121 MS28774-126	2-10-71 2-10-86 2-4-16 2-5-138 2-6-138 2-7-138 2-8-138 2-10-88 2-10-79 2-10-102 2-10-81 2-1-15 2-5-270 2-6-270 2-7-270 2-8-270 2-10-70
MS24665-300	2-10-1	MS27240-1	2-2-20 2-2-51 2-3-20 2-3-51 2-2-28 2-2-57 2-3-56 2-2-28 2-3-28 2-6-215L 2-8-215L	MS28774-214 MS28774-218 MS28774-230 MS28774-346 MS28775-012	2-5-270 2-6-270 2-7-270 2-8-270 2-10-70
MS24665-302	2-10-6	MS27291-1	2-2-51 2-3-20 2-3-51 2-2-28 2-3-28 2-6-215L 2-8-215L	MS28775-013	2-5-180 2-6-180 2-7-180 2-8-180 2-5-2618 2-6-2618 2-7-2618 2-8-2618 2-5-281 2-6-281 2-7-281 2-8-281 2-4-17 2-10-618 2-5-139 2-6-139 2-7-139 2-8-139 2-9-10 2-4-9 2-13-30 2-1-132 2-5-261F 2-5-222V 2-5-222W 2-6-261F 2-6-218 2-6-218E 2-7-261F 2-7-222V 2-7-222W 2-8-261F 2-8-218 2-8-218E
MS24665-304	2-9-17	MS27369E0107	2-2-51 2-3-20 2-3-51 2-2-28 2-3-28 2-6-215L 2-8-215L	MS28775-017	2-5-180 2-6-180 2-7-180 2-8-180 2-5-2618 2-6-2618 2-7-2618 2-8-2618 2-5-281 2-6-281 2-7-281 2-8-281 2-4-17 2-10-618 2-5-139 2-6-139 2-7-139 2-8-139 2-9-10 2-4-9 2-13-30 2-1-132 2-5-261F 2-5-222V 2-5-222W 2-6-261F 2-6-218 2-6-218E 2-7-261F 2-7-222V 2-7-222W 2-8-261F 2-8-218 2-8-218E
MS24665-368	2-5-376 2-6-376 2-7-376 2-8-376	MS27369G0096 MS27369G0170	2-2-28 2-3-28 2-6-215L 2-8-215L	MS28775-115	2-5-180 2-6-180 2-7-180 2-8-180 2-5-2618 2-6-2618 2-7-2618 2-8-2618 2-5-281 2-6-281 2-7-281 2-8-281 2-4-17 2-10-618 2-5-139 2-6-139 2-7-139 2-8-139 2-9-10 2-4-9 2-13-30 2-1-132 2-5-261F 2-5-222V 2-5-222W 2-6-261F 2-6-218 2-6-218E 2-7-261F 2-7-222V 2-7-222W 2-8-261F 2-8-218 2-8-218E
MS24665-372	2-5-99 2-6-99 2-7-99 2-8-99	MS27369G0184 MS27369G0194 MS27371H0176	2-2-57 2-3-56 2-2-28 2-3-28 2-6-215L 2-8-215L	MS28775-116	2-5-180 2-6-180 2-7-180 2-8-180 2-5-2618 2-6-2618 2-7-2618 2-8-2618 2-5-281 2-6-281 2-7-281 2-8-281 2-4-17 2-10-618 2-5-139 2-6-139 2-7-139 2-8-139 2-9-10 2-4-9 2-13-30 2-1-132 2-5-261F 2-5-222V 2-5-222W 2-6-261F 2-6-218 2-6-218E 2-7-261F 2-7-222V 2-7-222W 2-8-261F 2-8-218 2-8-218E
MS24665-378	2-5-164 2-6-164 2-7-164 2-8-164	MS27371H0214 MS27372H0210200	2-6-215M 2-8-215M 2-5-215A 2-5-222U 2-7-215A 2-7-222U 2-5-215K 2-5-222 2-7-215K 2-7-222 2-6-215A 2-6-218Q 2-8-215A 2-8-218Q 2-5-215L 2-5-222A 2-7-215L 2-7-222A 2-6-215B 2-6-218P 2-8-215B 2-8-218P 2-5-215D 2-5-222T 2-7-215D 2-7-222T	MS28775-121 MS28775-125 MS28775-126	2-5-180 2-6-180 2-7-180 2-8-180 2-5-2618 2-6-2618 2-7-2618 2-8-2618 2-5-281 2-6-281 2-7-281 2-8-281 2-4-17 2-10-618 2-5-139 2-6-139 2-7-139 2-8-139 2-9-10 2-4-9 2-13-30 2-1-132 2-5-261F 2-5-222V 2-5-222W 2-6-261F 2-6-218 2-6-218E 2-7-261F 2-7-222V 2-7-222W 2-8-261F 2-8-218 2-8-218E
MS24665-439	2-13-1	MS27372H0224200	2-6-215M 2-8-215M 2-5-215A 2-5-222U 2-7-215A 2-7-222U 2-5-215K 2-5-222 2-7-215K 2-7-222 2-6-215A 2-6-218Q 2-8-215A 2-8-218Q 2-5-215L 2-5-222A 2-7-215L 2-7-222A 2-6-215B 2-6-218P 2-8-215B 2-8-218P 2-5-215D 2-5-222T 2-7-215D 2-7-222T	MS28775-431 MS28776-6 MS28776-70 MS28778-10	2-5-180 2-6-180 2-7-180 2-8-180 2-5-2618 2-6-2618 2-7-2618 2-8-2618 2-5-281 2-6-281 2-7-281 2-8-281 2-4-17 2-10-618 2-5-139 2-6-139 2-7-139 2-8-139 2-9-10 2-4-9 2-13-30 2-1-132 2-5-261F 2-5-222V 2-5-222W 2-6-261F 2-6-218 2-6-218E 2-7-261F 2-7-222V 2-7-222W 2-8-261F 2-8-218 2-8-218E
MS24675-12	2-6-215Y	MS27373H0156190	2-5-215A 2-5-222A 2-7-215L 2-7-222A 2-6-215B 2-6-218P 2-8-215B 2-8-218P 2-5-215D 2-5-222T 2-7-215D 2-7-222T		
MS24678-10	2-6-215X 2-6-218J 2-8-215U 2-8-218J 2-6-217L 2-8-215V 2-8-217L	MS27372H0240124	2-6-215A 2-6-218Q 2-8-215A 2-8-218Q 2-5-215L 2-5-222A 2-7-215L 2-7-222A 2-6-215B 2-6-218P 2-8-215B 2-8-218P 2-5-215D 2-5-222T 2-7-215D 2-7-222T		
MS24678-12	2-6-217L 2-8-215V 2-8-217L	MS27373H0172000	2-6-215B 2-6-218P 2-8-215B 2-8-218P 2-5-215D 2-5-222T 2-7-215D 2-7-222T		
MS24690	2-1-16 2-5-272 2-6-272 2-7-272 2-8-272	MS27374H0244045	2-6-215B 2-6-218P 2-8-215B 2-8-218P 2-5-215D 2-5-222T 2-7-215D 2-7-222T		
MS24693S31	2-5-128A 2-5-129A 2-6-128A 2-6-129A 2-7-128A 2-7-129A 2-8-128A 2-8-129A 2-5-128A 2-5-129A 2-6-128A 2-6-129A 2-7-128A 2-7-129A 2-8-128A 2-8-129A	MS28013-1	2-5-262 2-6-262 2-7-262 2-8-262 2-1-138 2-5-228 2-6-228 2-7-228 2-8-228		
MS25082-1	2-5-128A 2-5-129A 2-6-128A 2-6-129A 2-7-128A 2-7-129A 2-8-128A 2-8-129A	MS28773-04			
MS25082-3	2-5-123 2-6-123 2-7-123				



PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
MS28778-4	2-1-90	MS28932-1	2-10-46	M81223-76R1212N	2-16-20
	2-1-109		2-10-94	M81223-76R1624N	2-16-61
	2-1-137	MS29513-279	2-13-31	M81223-76R16246	2-16-49
	2-2-22			M81223-76R1831N	2-16-39
	2-2-54	MS3124F14-19S	2-15-29	M81223-76R22556	2-16-29
	2-3-22	MS3124F14-19SW	2-16-58	NA1103-15	2-1-121
	2-3-53	MS3126F14-19P	2-14-24P		
	2-4-27		2-15-35Q	NA1103-2	2-1-88
	2-5-210	MS3126F14-19PW	2-14-24N	NA1103-23	2-1-118
	2-5-229		2-15-35P	NAS1103-4	2-6-349B
	2-5-265	MS35206-218	2-14-30		2-8-349B
	2-5-267		2-15-65	NA1103-44	2-1-121A
	2-5-393	MS35265-14	2-5-216		2-14-26A
	2-5-222H		2-6-216		2-15-33
	2-6-210		2-7-216	NA1103-52	2-1-118A
	2-6-216L		2-8-216		2-14-26A
	2-6-229	MS35265-41	2-4-45		2-15-38
	2-6-265		2-5-64	NA1103-12	2-5-257
	2-6-267		2-6-64		2-6-257
	2-6-393		2-7-64		2-7-257
	2-7-210		2-8-64		2-8-257
	2-7-229	MS35338-43	2-5-125	NA1103-130	2-5-214
	2-7-265		2-6-125		2-6-214
	2-7-267		2-7-125		2-7-214
	2-7-393		2-8-125		2-8-214
	2-7-222H	MS35489-10	2-2-12	NA1103-18	2-1-31
	2-8-210		2-3-12		2-5-141
	2-8-216L	MS35489-42	2-2-13		2-6-141
	2-8-229		2-3-13		2-7-141
	2-8-265			NA1103-43	2-8-141
	2-8-267	MS35674-17	2-5-84	NAS1103-52	2-1-22
	2-8-393		2-6-84		2-5-198
	2-10-63		2-7-84		2-6-198
	2-10-69		2-8-84		2-7-198
MS28778-5	2-1-30	MS665-368	2-5-376		2-8-198
	2-2-18	MS9058-04	2-4-38		
MS28778-6	2-2-30	M129-51	2-15-90	NA1103-8	2-5-261
	2-2-33	M129-52	2-14-28		2-6-261
	2-2-60		2-15-56		2-7-261
	2-2-62	M129-53	2-14-73		2-8-261
	2-3-18	M39029/4-20-20	2-16-21	NA1103-70	2-2-8
	2-3-30		2-16-30		2-3-8
	2-3-33		2-16-40	NA1103-15	2-5-372
	2-3-59		2-16-50		2-6-372
	2-5-156		2-16-62		2-7-372
	2-6-156	M39029/5-20-20	2-16-5		2-8-372
	2-7-156		2-16-13		2-5-32
	2-8-156		2-16-73		2-5-365
MS28778-8	2-4-23	M7928/1-22	2-14-47F		2-6-32
	2-5-162		2-15-36H		2-6-365
	2-5-173		2-16-2		2-7-32
	2-5-222R		2-16-10		2-7-365
	2-6-162		2-16-27		2-8-32
	2-6-173		2-16-37		2-8-365
	2-6-216		2-16-45	NA1103-33	2-4-48
	2-6-217S		2-16-68	NA1103-4	2-1-18
	2-7-162	M7928/1-24	2-14-47F		2-14-47
	2-7-173		2-15-36H	NA1103V12	2-2-5
	2-7-222R		2-16-3		2-3-5
	2-8-162		2-16-11	NA1103V2	2-2-20
	2-8-173		2-16-69		2-2-19
	2-8-216				2-2-23
	2-8-217S	M7928/1-33	2-16-28		2-2-39
MS28889-1	2-5-263		2-16-46		2-2-50
	2-6-263	M81824/1-2	2-16-17		2-3-2E
	2-7-263	M83723-75R10056	2-16-72		2-3-19
	2-8-263	M83723-75R10057	2-16-4		2-3-23
	2-10-68		2-16-12		2-3-43

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
NAS1133V2	2-3-66	NAS1305-14	2-5-250A		2-16-52
NAS1133V3	2-2-34		2-6-250A		2-16-63
	2-2-63		2-7-250A		2-16-70
	2-3-34		2-8-250A		2-16-74
	2-3-62	NAS1306-1H	2-5-231	NAS2806-20	2-1-62
			2-6-231		2-5-37
NAS1133V4	2-2-27		2-7-231		2-6-37
	2-2-55		2-8-231		2-7-37
	2-3-27	NAS1306-5	2-5-71		2-8-37
	2-3-54		2-6-71	NAS430D1-28	2-5-128A
NAS1191-3P6	2-5-188		2-7-71		2-5-129A
	2-6-188		2-8-71		2-6-128A
	2-7-188	NAS1308-26	2-5-343		2-6-129A
	2-8-188		2-6-343		2-7-128A
NAS1202-6	2-5-154		2-7-343		2-7-129A
NAS1204-6H	2-5-91		2-8-343		2-8-128A
NAS1291X8	2-5-184	NAS1351C4LN14	2-5-337	NAS430D3-16	2-8-129A
	2-6-184		2-6-337		2-14-47E
	2-7-184		2-7-337	NAS430D3-28	2-15-368
	2-8-184		2-8-337		2-5-221D
NAS1303-1H	2-4-60				2-7-221D
	2-5-366	NAS1423-4	2-1-44	NAS430D3-32	2-6-221J
	2-6-366		2-11-1		2-8-221J
	2-7-366	NAS1423-9	2-5-219		2-15-78
	2-8-366		2-6-219	NAS430D3-48	2-14-12
NAS1303-14D	2-5-279		2-7-219		2-14-50
	2-6-279		2-8-219		2-15-34
	2-7-279	NAS1624-24	2-5-288	NAS430D3-64	2-14-26
	2-8-279		2-6-288	NAS430D3-72	2-14-98
	2-15-73		2-7-288		
NAS1303-20	2-6-215S		2-8-288	NAS430D3-80	2-14-22
	2-8-215S	NAS1624-9	2-1-57A	NAS430D4-22	2-1-28
NAS1303-21D	2-5-280		2-5-48	NAS430D4-28	2-14-103
	2-6-280		2-5-53		2-15-90
	2-7-280		2-6-48		2-15-110
	2-8-280		2-6-53	NAS430D4-32	2-6-387
NAS1303-6	2-1-39		2-7-48		2-8-387
	2-5-154		2-7-53	NAS509-12	2-10-77
	2-6-154		2-8-48	NAS509-4	2-5-81
	2-7-154		2-8-53		2-5-233
	2-8-154	NAS1633-10	2-5-221A		2-5-235
			2-7-221A		2-6-81
NAS1304-1HW	2-5-240	NAS1633-11	2-6-221C		2-6-233
	2-5-330		2-8-221C		2-6-235
	2-6-240	NAS1634-16	2-1-68		2-7-81
	2-6-330		2-5-25		2-7-233
	2-7-240		2-6-25		2-7-235
	2-7-330		2-7-25		2-8-81
	2-8-240		2-8-25		2-8-233
	2-8-330	NAS1634-21	2-1-69		2-8-235
NAS1304-2H	2-5-217		2-5-57	NAS551-5H	2-1-14
	2-6-221G		2-6-57		2-5-269
	2-7-217		2-7-57		2-6-269
	2-8-221G		2-8-57		2-7-269
NAS1304-22H	2-5-223	NAS1634-3	2-1-57		2-8-269
	2-6-223		2-5-53	NAS559-1	2-5-82
	2-7-223		2-6-53		2-6-82
	2-8-223		2-7-53		2-7-82
NAS1304-4H	2-5-217		2-8-53		2-8-82
	2-6-217M	NAS1634-9	2-1-56	NAS577-4A	2-1-36
	2-6-221G		2-5-42		2-5-146
	2-7-217		2-6-42		2-6-146
	2-8-217M		2-7-42		2-7-146
	2-8-221G		2-8-42		2-8-146
NAS1304-6H	2-5-91	NAS1745-14	2-16-18	NAS577-3A	2-5-3448
	2-6-91	NAS1745-15	2-16-23		2-6-3448
	2-7-91		2-16-47		2-7-3448
	2-8-91				2-8-3448

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
NAS600-10P	2-5-221A 2-7-221A 2-14-74 2-14-76 2-14-91 2-15-100	NAS603-7P	2-15-5A 2-15-44 2-15-73 2-15-105 2-14-47A 2-14-47C	NAS676V5H NAS814-8	2-6-370 2-7-370 2-8-370 2-4-40 2-5-215W 2-5-222D 2-5-222N 2-6-216R 2-6-222D 2-7-215R 2-7-222D 2-7-222N 2-8-215Y 2-8-216R
NAS601-10P	2-5-130B 2-5-130D 2-6-130B 2-6-130D 2-7-130B 2-7-130D 2-8-130B 2-8-130D	NAS603-72P	2-15-36C 2-15-36E 2-15-36F 2-5-128 2-6-128 2-7-128 2-8-128	NAS924-4D NO NUMBER	2-1-105 2-1-140 2-5-6 2-5-328 2-5-386 2-6-6 2-6-328 2-6-386 2-7-6 2-7-328 2-7-386 2-8-6 2-8-328 2-8-386 2-9- 2-10- 2-13- 2-10-5 2-16-22
NAS601-6P	2-5-130C 2-6-130C 2-7-130C 2-8-130C	NAS603-8P	2-2-19 2-2-23 2-2-39 2-2-50 2-3-2E 2-3-19 2-3-23 2-5-387 2-6-280D 2-7-387 2-8-280D 2-14-3A 2-14-7 2-14-13 2-14-18B 2-14-24H 2-14-27C 2-14-29 2-14-50 2-14-58 2-14-61 2-14-70 2-15-5A 2-15-15 2-15-20 2-15-25 2-15-28 2-15-35B 2-15-39 2-15-66 2-15-73 2-15-78 2-15-83 2-15-88 2-1-143 2-14-28 2-15-56C	PBF1042A6D20 RBB22 RC50-3CL RM52LHA4972-10-02 RM52LHA4972-8-82 RS318CD RS450CD R5 SS48155 SS48175 STSCD006-06 STSP2102J0S10 STSPB202J080804	2-1-105 2-1-140 2-5-6 2-5-328 2-5-386 2-6-6 2-6-328 2-6-386 2-7-6 2-7-328 2-7-386 2-8-6 2-8-328 2-8-386 2-9- 2-10- 2-13- 2-10-5 2-16-22 2-5-341 2-6-341 2-7-341 2-8-241 2-14-28 2-15-56C 2-14-28 2-15-56C 2-13-6 2-13-13 2-1-34 2-5-144 2-6-144 2-7-144 2-8-144 2-5-329A 2-6-329A 2-7-329A 2-8-329A 2-5-329 2-6-329 2-7-329 2-8-329 2-5-221B 2-6-221L 2-7-221B 2-8-221L 2-6-217K 2-8-217K
NAS601-8P	2-4-43 2-5-66 2-6-66 2-7-66 2-8-66				
NAS602-12P	2-14-28 2-14-73 2-15-56 2-15-90				
NAS602-6P	2-15-8 2-15-56C				
NAS602-8P NAS603-10P	2-14-28 2-2-27 2-2-55 2-3-2E 2-3-27 2-3-43 2-3-54 2-3-66 2-5-130A 2-5-221A 2-7-130A 2-7-221A 2-8-130A 2-14-47E 2-15-36B	NAS620C416L NAS6203-3	2-15-78 2-15-83 2-15-88 2-1-143 2-14-28 2-15-56C		
NAS603-16P	2-6-221C 2-8-221C 2-15-78				
NAS603-18P	2-14-13 2-14-50				
NAS603-22P NAS603-24P NAS603-26P	2-14-63 2-9-4 2-14-26 2-14-98	NAS6204-9H	2-1-24 2-1-24A 2-14-102 2-15-90 2-15-108 2-5-245 2-6-245 2-7-245 2-8-245 2-15-90 2-5-250 2-6-250 2-7-250 2-8-250 2-15-90 2-4-64 2-5-370		
NAS603-30P	2-5-127 2-6-127 2-7-127 2-8-127 2-14-26 2-15-5A 2-15-51 2-2-34 2-2-63 2-3-34 2-3-62 2-14-55 2-14-90 2-14-105	NAS6205-13D			
NAS603-6P		NAS6205-15D			
		NAS623-3-7			

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
STSPB202J080804	2-7-222G	T4G04104-115A	2-5-215H		2-6-218G
	2-8-215W		2-5-222C		2-8-215C
	2-8-216N		2-7-215H		2-8-218G
STSRB001D0810	2-5-261G		2-7-222C	T4G04105-101A	2-4-1
	2-6-261G			T4G04105-103A	2-4-2
	2-7-261G	T4G04104-117A	2-5-215J	T4G04105-105A	2-4-3
	2-8-261G		2-5-222B		
S12561-451	2-10-37		2-7-215J	T4G04105-107A	2-4-28
S34468P5	2-10-38		2-7-222B	T4G04105-109A	2-4-13
TRIPLE 148	2-5-342	T4G04104-119A	2-5-215G	T4G04105-111A	2-4-10
	2-6-342		2-5-222K	T4G04105-113A	2-4-32
	2-7-342		2-7-215G	T4G04105-115A	2-4-29
	2-8-342		2-7-222K	T4G04105-117A	2-4-1
TRIPLE 148C/L	2-5-341		2-14-24M	T4G04105-119A	2-4-2
	2-6-341	T4G04104-121A	2-5-215F	T4G04105-121A	2-4-3
	2-7-341		2-5-222L	T4G04105-123A	2-4-28
	2-8-341		2-7-215F	T4G04105-125A	2-4-13
T1380-09	2-14-47F		2-7-222L		
	2-15-36H		2-15-35C	T4G04105-127A	2-4-10
T1380-12	2-16-24	T4G04104-123A	2-5-215E	T4G04105-129A	2-4-32
T1380-16	2-16-35		2-5-222M	T4G04105-131A	2-4-29
	2-16-56		2-7-215E	T4G04105-133A	2-4-36
	2-16-66		2-7-222M	VAL23602-6DS20	2-10-5
		T4G04104-125A	2-6-215D	VSF1238F040604	2-4-26
			2-6-216H	VSF1250F0404	2-2-26
T1380-6	2-16-43		2-8-215D	VSF1267F0404	2-2-25
T4G04100-111A	2-2-15		2-6-216H	VSF1267F0606	2-2-2C
	2-3-15	T4G04104-127A	2-6-215E	VSF1270F040404	2-2-38
T4G04100-117A	2-2-1		2-6-216G		
T4G04100-119A	2-3-1		2-8-215E	VSF1270F060604	2-1-126
T4G04101-151A	2-2-42		2-8-216G	VSF1270F080804	2-4-8
	2-3-46		2-6-215F	VSF1275F060804	2-4-11
T4G04101-153A	2-2-43	T4G04104-129A	2-6-216J	VSF1279F0404	2-2-40
	2-3-47		2-8-215F	VSF1279F0606	2-2-2A
T4G04101-155A	2-2-49		2-8-216J	VSF1280F0604	2-2-37
T4G04101-159A	2-2-45		2-6-215G	VSF1280F0606	2-2-2
T4G04101-161A	2-2-23	T4G04104-131A	2-6-216M	VSF1280F0808	2-4-7
	2-5-220B		2-8-215G	VSF1282F0404	2-2-21
	2-7-220B		2-8-216M	VSF1282F0606	2-2-17
T4G04101-165A	2-3-41		2-6-215H		
	2-6-221E	T4G04104-133A	2-6-216C	VSF1287F0808	2-4-25
	2-8-221E		2-6-217A	VS2979A06D020	2-10-5
			2-8-215H	Z1200	2-1-57A
T4G04101-169A	2-3-24		2-8-216C		2-5-26
T4G04101-171A	2-3-49		2-8-217A		2-6-26
T4G04101-173A	2-3-43		2-6-215J		2-7-26
	2-6-221A	T4G04104-135A	2-6-216E		2-8-26
	2-8-221A		2-6-217C		2-13-32
T4G04101-177A	2-3-23		2-8-215J		
T4G04101-179A	2-2-41		2-8-216E	07-311-200-891E-001	2-10-65
	2-3-45		2-8-217C	1-03076C4	2-5-218
T4G04101-201A	2-2-36		2-15-35A	1-899-101-1	2-6-218
T4G04101-203A	2-2-46				2-7-218
T4G04101-205A	2-3-36				2-8-218
T4G04101-207A	2-3-38	T4G04104-137A	2-6-215K		2-1-18
T4G04101-209A	2-3-67		2-6-216D	1-899-15	2-14-47
			2-6-217B		2-5-266
T4G04101-211A	2-2-65		2-8-215K	1000-38	2-6-266
T4G04101-213A	2-2-39		2-8-216D		2-7-266
	2-5-220A		2-8-217B		2-8-266
	2-7-220A	T4G04104-139A	2-5-215Q		2-10-66
	2-2-24		2-6-215U		2-15-75
T4G04102-103A	2-14-24G	T4G04104-141A	2-5-215P	1004-100905	2-14-47F
T4G04104-101A	2-3-68		2-6-215V	1004-101205	2-15-36H
T4G04104-103A	2-1-82	T4G04104-143A	2-7-215N		
T4G04104-109A	2-3-70		2-8-215T		
T4G04104-111A	2-5-215N	T4G04104-145A	2-1-101	1004-120905	2-14-66
	2-6-215T	T4G04104-149A	2-1-136	1004-121205	2-14-4
T4G04104-113A	2-3-69	T4G04104-165A	2-6-215C		2-14-47F

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
1004-121205	2-14-52 2-14-56 2-14-72 2-15-17 2-15-23 2-15-36H 2-15-43 2-15-80 2-15-86 2-15-89 2-16-6 2-16-14 2-16-75	179-50074 179-50075 179-50076	2-1-97 2-1-93 2-5-226 2-6-226 2-7-226 2-8-226 2-1-74 2-1-73 2-1-115	2-03014F06	2-2-26 2-2-52 2-3-25 2-3-26 2-3-50 2-2-2 2-2-15 2-2-37 2-2-47 2-2-66 2-3-2 2-3-15 2-3-37 2-3-39
1004-141205	2-14-18 2-15-48 2-16-75		2-2-40 2-2-44 2-3-44 2-3-48 2-3-65 2-4-30	2-03014F08	2-4-4 2-4-6 2-5-215V 2-6-222C 2-7-215Q 2-8-215X
1004-141605	2-14-8 2-14-19 2-15-22 2-15-29 2-15-40 2-16-34 2-16-42 2-16-55 2-16-65	2-01090F0404  2-01090F0606  2-01096F0404  2-01096F0604	2-2-2A 2-2-3 2-3-2A 2-3-3 2-2-26 2-2-52 2-3-26 2-2-37 2-2-47 2-2-66 2-3-37 2-3-39	2-171S604-70 20261SL475 209SZZ 22266780	2-12-12 2-10-74 2-11-26 2-5-247B 2-6-247B 2-7-247B 2-8-247B
1004-192405	2-14-27		2-2-2 2-2-2 2-2-32 2-2-59 2-3-2 2-3-32 2-3-58 2-4-5	22558-110	2-2-15D 2-3-15D 2-5-356 2-6-356 2-7-356 2-8-356
1019-101205	2-15-23 2-15-89 2-16-7 2-16-15 2-16-76	2-01096F0606	2-3-39 2-2-2 2-2-32 2-2-59 2-3-2 2-3-32 2-3-58 2-4-5	246-15	2-1-39 2-5-160 2-6-160 2-7-160 2-8-160 2-4-15 2-4-22 2-4-18
1019-121205	2-16-25		2-5-215U 2-6-222B 2-7-215P 2-8-215X	2690079	2-1-39 2-5-160 2-6-160 2-7-160 2-8-160
1019-161605	2-16-41 2-16-64 2-16-54	2-01096F0806	2-4-7 2-4-25 2-3-60 2-2-25 2-3-25 2-3-50 2-2-2C	29936 29937 29938	2-4-15 2-4-22 2-4-18
1019-181605		2-01535F0606 2-01590F0404	2-2-21 2-2-53 2-3-21 2-3-52 2-4-31 2-2-17 2-2-29 2-2-61 2-3-17 2-3-29 2-2-38 2-2-48 2-3-40 2-3-42 2-1-125 2-5-215R 2-6-215W 2-4-8 2-4-11 2-4-26 2-2-25	29939 326FK2N 326FR2T 326FTE160A 351-45100-312A 353-12-06-001 353-12-10-001 353-12-12-001 353-12-14-001	2-4-14 2-10-103 2-10-104 2-10-105 2-10-47 2-15-100 2-14-76 2-14-74 2-14-30 2-15-65 2-15-101
1019-221605	2-16-33	2-01595F0404		363-11-06-011	
102C1050	2-5-358 2-6-358 2-7-358 2-8-358	2-01096F0808		363-11-10-011 363-11-12-011 363-11-14-011	2-14-77 2-14-75 2-14-31 2-15-64
102C164-1	2-5-361 2-6-361 2-7-361 2-8-361 2-5-360 2-6-360 2-7-360 2-8-360	2-01590F0606		4869008-109A	2-5-221D 2-7-221D 2-6-221H 2-8-221H 2-6-221J 2-8-221J 2-6-221F 2-8-221F 2-6-221F
102D142-1	2-5-360 2-6-360 2-7-360 2-8-360	2-01595F0606		4869008-113A 4869008-115A 4869012-101A 4869012-103A	
1031-141605	2-14-19 2-15-29	2-02269F040404			
11612001	2-5-383 2-6-383 2-7-383 2-8-383				
11613001	2-5-375 2-6-375 2-7-375 2-8-375	2-02269F0606C4			
118-00017	2-1-117	2-02269F080804 2-02286F060804 2-02295F040604 2-03014F04			
118-00019	2-5-215M 2-7-215M				
118-00048	2-1-144				
118-00049	2-1-147				
179-50070	2-1-104				
179-50071	2-1-106				
179-50072	2-1-108				

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
4869012-103A	2-8-221F		2-14-24E	4869143-137A	2-14-94
4869013-101A	2-5-219	4869142-105A	2-14-20		2-16-40
	2-7-219		2-16-5	4869143-139A	2-14-96
4869013-103A	2-5-219	4869142-107A	2-14-62		2-16-63
4869013-103A	2-7-219		2-16-13	4869143-141A	2-14-19
4869016-101A	2-5-130	4869142-109A	2-14-56		2-14-24D
	2-7-130	4869142-111A	2-14-59	4869143-145A	2-15-22
4869016-102A	2-6-130		2-16-74	4869143-159A	2-15-40
	2-8-130	4869142-113A	2-14-66	4869143-161A	2-15-29
4869017-101A	2-6-129	4869142-115A	2-14-4	4869143-163A	2-16-36
	2-8-129	4869142-117A	2-15-35F	4869143-165A	2-16-57
4869017-102A	2-5-129		2-15-48	4869143-167A	2-16-67
	2-7-129	4869142-119A	2-14-72	4869143-169A	2-16-36
4869019-101A	2-5-130D	4869142-121A	2-14-16	4869143-171A	2-16-67
	2-7-130D		2-15-9	4869143-175A	2-14-19
4869019-102A	2-6-130D		2-16-23	4869143-177A	2-16-44
	2-8-130D	4869142-127A	2-15-75	4869143-179A	2-16-57
4869020-101A	2-6-130B	4869142-129A	2-15-23	4869143-181A	2-16-44
	2-8-130B	4869142-131A	2-15-43	4869143-189A	2-15-22
4869020-102A	2-5-130B	4869142-133A	2-15-45		
	2-7-130B		2-16-74	4869143-195A	2-14-8
		4869142-135A	2-15-89	4869143-197A	2-14-8
4869020-103A	2-5-130B			4869144-111A	2-14-27
	2-6-130B	4869142-137A	2-15-80	4869144-129A	2-14-27
	2-7-130B	4869142-139A	2-15-86	4869150-101A	2-14-28
	2-8-130B	4869142-143A	2-15-17	4869150-103A	2-14-40
4869021-101A	2-5-130C	4869142-145A	2-16-8	4869150-105A	2-14-43
	2-6-130C	4869142-147A	2-16-16	4869151-101A	2-14-73
	2-7-130C	4869142-149A	2-16-77	4869151-103A	2-15-90
	2-8-130C	4869142-151A	2-14-4	4869151-105A	2-14-90
4869022-101A	2-5-131	4869142-153A	2-14-72		
	2-6-131	4869142-155A	2-16-26	4869151-107A	2-14-91
	2-7-131	4869142-161A	2-15-23	4869151-109A	2-14-89
	2-8-131			4869151-111A	2-15-105
4869024-101A	2-5-130A	4869142-163A	2-15-89	4869151-113A	2-14-90
	2-6-130A	4869142-165A	2-15-86	4869151-115A	2-14-55
	2-7-130A	4869142-169A	2-15-17		2-15-44
	2-8-130A	4869142-171A	2-15-80	4869151-117A	2-14-92
4869130-105A	2-1-2	4869142-173A	2-15-48	4869151-119A	2-15-106
	2-6-12	4869142-175A	2-14-52	4869151-121A	2-14-17
	2-8-12	4869142-177A	2-15-75	4869151-122A	2-15-8
	2-15-	4869142-179A	2-14-66	4869152-101A	2-15-
4869130-107A	2-1-2	4869142-181A	2-15-43		
	2-5-12	4869142-183A	2-14-18	4869152-103A	2-15-36G
	2-7-12				2-15-74
	2-14-	4869142-185A	2-16-77	4869153-101A	2-14-
4869134-101A	2-15-66	4869142-187A	2-14-56	4G11005-121A	2-1-57
4869134-102B	2-14-29	4869142-189A	2-14-47F		2-5-33
4869135-101A	2-15-56C	4869142-191A	2-15-36H		2-6-33
4869135-103A	2-15-67	4869142-193A	2-14-47F		2-7-33
		4869142-195A	2-15-36H		2-8-33
4869135-105A	2-15-70	4869143-121A	2-15-40	4G11005-131A	2-1-28
4869137-103A	2-14-5	4869143-123A	2-15-29	4G11008-117A	2-1-1
	2-14-51		2-15-35H		2-2-
	2-14-71	4869143-125A	2-15-52		2-5-11
	2-15-16		2-16-32	4G11008-118A	2-6-11
	2-15-79	4869143-127A	2-15-54	4G11008-119A	2-1-1
	2-15-85		2-16-53		2-3-
4869137-105A	2-14-64			4G11008-121A	2-1-1
4869137-107A	2-14-9	4869143-129A	2-15-53		2-2-
	2-15-21		2-16-40		2-7-11
4869140-101A	2-5-217	4869143-131A	2-15-55	4G11008-123A	2-1-1
	2-6-217		2-16-63		2-3-
	2-7-217	4869143-133A	2-14-93		2-8-11
	2-8-217		2-16-32	4G11016-101A	2-2-
	2-14-52	4869143-135A	2-14-95		
4869142-103A	2-14-18		2-16-53	4G11016-103A	2-3-

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
4G11016-105A	2-2-14	4G11441-101A	2-5-244		2-7-252
4G11019-101A	2-3-14		2-6-244	4G12042-102A	2-8-252
	2-1-48		2-7-244		2-5-253
4G11019-103A	2-4-	4G11447-101A	2-8-244		2-6-253
	2-1-48		2-5-303		2-7-253
4G11019-105A	2-4-		2-6-303	4G12043-101B	2-8-253
	2-4-42	4G11447-103A	2-7-303		2-5-251
	2-5-63		2-8-303		2-6-251
	2-6-63		2-5-305		2-7-251
	2-7-63		2-6-305	4G12044-105A	2-8-251
	2-8-63		2-7-305		2-5-93
4G11019-107A	2-4-58	4G11448-107A	2-8-305		2-6-93
	2-5-117	4G11448-109A	2-9-11		2-7-93
	2-6-117	4G11453-101B	2-9-15	4G12047-101A	2-8-93
	2-7-117		2-5-295		2-5-349
	2-8-117		2-6-295	4G12048-101A	2-7-349
4G11020-101A	2-1-		2-7-295		2-4-54
4G11020-103A	2-1-		2-8-295		2-5-348
4G11020-105A	2-1-	4G11453-103B	2-5-297		2-6-348
4G11020-107A	2-1-		2-6-297		2-6-349
			2-7-297		2-7-348
4G11400-137A	2-1-72		2-8-297		2-7-349
	2-7-	4G11454-101D	2-5-208		2-8-348
4G11400-139A	2-1-72		2-6-208	4G12049-101A	2-8-349
	2-8-		2-7-208		2-6-347C
4G11400-141A	2-1-72		2-8-208	4G12049-102A	2-8-347C
	2-6-				2-1-19A
4G11400-143A	2-1-72	4G11458-101A	2-5-247		2-6-347A
	2-5-		2-6-247		2-8-347A
<del>4G11414-107A</del>	2-10-112		2-7-247	4G12050-101A	2-6-347D
4G11414-109A	2-10-118		2-8-247		2-8-347D
4G11415-107A	2-5-385	4G11476-101B	2-5-319	4G12050-102A	2-6-347B
	2-6-385		2-6-319		2-8-347B
	2-7-385		2-7-319		
	2-8-385	4G11476-103A	2-8-319	4G12050-102B	2-1-19B
	2-12-		2-5-327	4G12051-101A	2-5-354
4G11415-107C	2-5-385		2-6-327		2-6-354
	2-6-385		2-7-327		2-7-354
	2-7-385		2-8-327		2-8-354
	2-8-385	4G11476-107A	2-5-319	4G12055-101A	2-1-75
	2-12-		2-6-319	4G12077-101A	2-7-349
4G11415-109A	2-12-14		2-7-319	4G12272-101A	2-5-169
4G11416-101A	2-5-355		2-8-319	4G12400-101A	2-5-1
	2-6-355	4G11476-109A	2-5-327		2-6-1
	2-7-355		2-6-327		2-7-1
	2-8-355		2-7-327		2-8-1
			2-8-327	4G12408-101A	2-10-60
4G11416-101B	2-5-355	4G11478-109A	2-5-171	4G12409-101B	2-10-108
	2-6-355		2-6-171	4G12409-103A	2-10-110
	2-7-355		2-7-171	4G12423-101A	2-11-8
	2-8-355		2-8-171		
	2-11-	4G11481-101C	2-5-174	4G12423-103A	2-11-10
4G11416-101C	2-5-355		2-6-174	4G12432-101A	2-10-58
	2-6-355		2-7-174	4G12433-101A	2-5-181
	2-7-355		2-8-174		2-6-181
	2-8-355	4G12029-105A	2-5-104		2-7-181
	2-11-		2-6-104		2-8-181
4G11430-113B	2-13-19		2-7-104	4G12434-101A	2-5-320
4G11430-115A	2-13-34		2-8-104		2-6-320
4G11430-119A	2-13-19	4G12033-101A	2-5-95		2-7-320
4G11435-101A	2-13-12		2-6-95		2-8-320
4G11435-103A	2-13-18		2-7-95	4G12435-101A	2-11-19
4G11436-107A	2-13-5		2-8-95	4G12436-105A	2-5-334
4G11436-109A	2-13-11	4G12039-101B	2-2-7		2-6-334
4G11439-107B	2-10-18		2-3-7		2-7-334
					2-8-334
4G11439-109B	2-10-22	4G12042-101A	2-5-252	4G12436-107A	2-5-332
4G11439-113A	2-10-18		2-6-252		2-6-332

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
4G12436-107A	2-7-332		2-8-110		2-8-243
	2-8-332	4G12586-101A	2-5-113	4G13338-103A	2-5-325
4G12436-109A	2-5-333		2-6-113		2-6-325
	2-6-333		2-7-113		2-7-325
	2-7-333		<del>2-8-113</del>		2-8-325
	2-8-333	4G12586-103A	2-5-115		
4G12443-101A	2-5-394		2-6-115	4G13345-101A	2-5-191
	2-6-394		2-7-115		2-6-191
	2-7-394		2-8-115		2-7-191
	2-8-394	4G12627-105A	2-5-340		2-8-191
			2-6-340	4G13346-101A	2-5-4
4G12471-101A	2-5-292		2-7-340		2-5-9
	2-6-292	4G12627-107B	2-8-340		2-6-4
	2-7-292		2-1-47		2-6-9
	2-8-292		2-5-339		2-7-4
4G12500-101A	2-1-100		2-6-339		2-7-9
4G12504-101A	2-1-130		2-7-339		2-8-4
4G12505-101A	2-1-89		2-8-339		2-8-9
4G12506-101A	2-1-131	4G12636-101A	2-5-309	4G13347-101A	2-5-2
4G12509-101A	2-1-76		2-6-309		2-5-7
4G12510-101A	2-1-75		2-7-309		2-6-2
4G12517-101A	2-6-215P		2-8-309		2-6-7
	2-6-217A	4G12645-101G	2-5-230		2-7-2
	2-8-215P		2-6-230		2-7-7
	2-8-217A		2-7-230		<del>2-8-2</del>
4G12518-101A	2-6-215Q		2-8-230		<del>2-8-7</del>
	2-6-217F	4G12657-101B	2-5-354	4G13348-101A	2-13-22
	2-8-215Q		2-6-354	4G13366-101A	2-5-207
	2-8-217F		2-7-354		2-6-207
4G12520-101A	2-6-215R		2-8-354		2-7-207
	2-6-218H	4G12660-101A	2-5-193		<del>2-8-207</del>
	2-8-215R		2-6-193	4G13370-101A	2-5-170
	2-8-218H		2-7-193		2-6-170
			2-8-193		2-7-170
4G12535-109A	2-1-129	4G12790-101A	2-5-145		2-8-170
4G12536-101A	2-5-242			4G13372-101A	2-5-169
	2-6-242	4G13085-123A	2-1-42		2-6-169
	2-7-242		2-5-157		2-7-169
	2-8-242		2-6-157		2-8-169
4G12538-111A	2-1-128		2-7-157	4G13376-103A	2-5-203
4G12539-101A	2-5-247C		2-8-157		2-6-203
	2-6-247C	4G13129-101A	2-1-25		2-7-203
	2-7-247C		2-14-48		2-8-203
	2-8-247C	4G13270-101A	2-5-170	4G13377-101A	2-5-206
4G12559-101A	2-6-215S	4G13292-101A	2-5-179		2-6-206
	2-8-215S	4G13311-101A	2-5-321		2-7-206
4G12559-101B	2-6-215S		2-6-321		2-8-206
	2-8-215S		2-7-321	4G13378-103A	2-5-205
4G12583-103A	2-5-137		2-8-321		2-6-205
	2-6-137	4G13312-101A	2-5-323		2-7-205
	2-7-137		2-6-323		2-8-205
	2-8-137		2-7-323		
4G12584-101A	2-5-96		2-8-323	4G13379-101A	2-5-202
	2-6-96		2-5-5		2-6-202
	2-7-96	4G13332-101A	2-5-10		2-7-202
	<del>2-8-96</del>		2-6-5		2-8-202
4G12584-103A	2-5-98		2-6-10	4G13382-103A	2-12-8
	2-6-98		2-7-5	4G13382-105A	2-12-8
	2-7-98		2-7-10	4G13382-109A	2-12-8
	2-8-98		2-8-5	4G13385-103A	2-12-7
4G12585-101A	2-5-108		2-8-10	4G13385-105A	2-12-7
	2-6-108	4G13335-101A	2-5-357	4G13390-101A	2-10-90
	<del>2-7-108</del>		2-6-357	4G13391-101A	2-5-287
	<del>2-8-108</del>		2-7-357		2-6-287
			2-8-357		2-7-287
4G12585-103A	2-5-110	4G13337-101A	2-5-243		2-8-287
	2-6-110		2-6-243	4G13392-101A	2-5-179
	2-7-110		2-7-243		2-6-179



PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
4G13392-101A	2-7-179 2-8-179	4G13513-101A	2-0-96		2-7-234 2-8-234
4G13402-101B	2-10-18A	4G13514-101A	2-10-107	4G13575-103A	2-5-296 2-6-296 2-7-296 2-8-296
4G13402-101C	2-10-18A	4G13515-101A	2-10-99	4G13575-105A	2-5-296 2-6-296 2-7-296
4G13403-101B	2-10-188	4G13516-101A	2-10-100	4G13586-101A	2-5-382 2-6-382 2-7-382 2-8-382
4G13403-101C	2-10-188	4G13518-101A	2-10-85	4G13588-105A	2-12-3
4G13407-103A	2-10-21	4G13519-101A	2-10-83	4G13591-103A	2-12-4
4G13412-101A	2-5-313 2-6-313 2-7-313 2-8-313	4G13520-101A	2-10-84	4G13591-105A	2-13-26
4G13413-101A	2-10-61	4G13521-101A	2-10-78	4G13592-103A	2-13-26
4G13419-101A	2-5-284 2-6-284 2-7-284 2-8-284	4G13522-101A	2-10-72	4G13592-107A	2-13-28
4G13420-101A	2-5-298 2-6-298 2-7-298 2-8-298	4G13524-105A	2-5-282 2-6-282 2-7-282 2-8-282	4G13593-103A	2-13-28
4G13431-101A	2-5-377 2-6-377 2-7-377 2-8-377	4G13525-101A	2-13-2	4G13595-103A	13-20
4G13433-101A	2-10-36	4G13529-103A	2-9-13	4G13595-105A	13-20
4G13434-101A	2-10-35	4G13529-105A	2-9-13	4G13597-103A	2-13-21
4G13435-101A	2-10-34	4G13530-103A	2-9-12	4G13597-105A	2-13-21
4G13436-101A	2-10-50	4G13530-105A	2-9-12	4G13598-101A	2-11-11
4G13437-101B	2-10-52	4G13533-103A	2-13-9	4G13600-101A	2-6-373 2-7-373 2-8-373
4G13437-105A	2-10-52	4G13533-105A	2-13-9	4G13601-101A	2-11-20
4G13440-101A	2-10-59	4G13534-103A	2-13-10	4G13602-101A	2-11-22
4G13487-101A	2-5-395 2-6-395 2-7-395 2-8-395	4G13534-105A	2-13-10	4G13603-101A	2-11-18
4G13487-102A	2-5-396 2-6-396 2-7-396 2-8-396	4G13535-103A	2-13-17	4G13604-101A	2-11-13
4G13488-101A	2-5-397 2-6-397 2-7-397 2-8-397	4G13535-105A	2-13-17	4G13605-103A	2-5-380 2-6-380 2-7-380 2-8-380
4G13490-105A	2-10-114	4G13536-103A	2-13-16	4G13606-101A	2-4-51 2-4-54 2-5-348 2-6-348 2-7-348 2-8-348
4G13490-109A	2-10-114	4G13536-105A	2-13-16	4G13608-101A	2-5-302 2-6-302 2-7-302 2-8-302
4G13490-117A	2-10-114	4G13537-101A	2-13-4	4G13609-103A	2-5-304 2-5-324 2-6-304 2-6-324
4G13491-103A	2-10-113	4G13538-101A	2-13-7	4G13610-103A	2-5-326
4G13491-105A	2-10-113	4G13539-101A	2-13-14		
4G13492-101A	2-10-11	4G13540-101A	2-13-8		
4G13495-101A	2-10-57	4G13541-101A	2-13-15		
4G13496-103A	2-10-56	4G13544-103A	2-10-20		
4G13499-101A	2-10-25	4G13558-101A	2-11-27		
4G13501-101A	2-10-55	4G13558-103A	2-11-30		
4G13502-101A	2-10-27	4G13560-101A	2-11-5		
4G13503-101A	2-10-26	4G13561-101A	2-5-195 2-6-195 2-7-195 2-8-195		
4G13504-101A	2-10-28	4G13563-103A	2-5-308 2-6-308 2-7-308 2-8-308		
4G13505-101A	2-10-33	4G13565-101B	2-5-317 2-6-317 2-7-317 2-8-317		
4G13506-101A	2-10-32	4G13569-101A	2-5-312 2-6-312 2-7-312 2-8-312		
4G13507-101A	2-10-30	4G13571-101A	2-5-311 2-6-311 2-7-311 2-8-311		
4G13508-101A	2-10-31	4G13572-103A	2-5-238 2-6-238 2-7-238 2-8-238		
4G13509-101A	2-10-29	4G13572-104A	2-5-239 2-6-239 2-7-239 2-8-239		
4G13510-101A	2-10-98	4G13574-101A	2-5-234 2-6-234		
4G13512-101A	2-10-97				

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
4G13610-103A	2-6-326		2-6-310		2-6-293
	2-7-326		2-7-310		2-7-293
	2-8-326		2-8-310		2-8-293
4G13610-105A	2-5-326	4G13686-101A	2-10-54	4G13769-101A	2-5-291
	2-6-326	4G13687-101A	2-5-344A		2-6-291
	2-7-326		2-6-344A		2-7-291
	2-8-326		2-7-344A		2-8-291
4G13611-103A	2-12-1		2-8-344A		
4G13612-101A	2-12-2	4G13688-101	2-8-379	4G13770-101A	2-5-294
		4G13688-101A	2-5-379		2-6-294
4G13612-103A	2-12-2		2-6-379		2-7-294
4G13613-101A	2-5-316		2-7-379		2-8-294
	2-6-316	4G13694-103A	2-5-374	4G13771-101A	2-5-194
	2-7-316		2-6-374		2-6-194
	2-8-316		2-7-374		2-7-194
<u>4G13614-101A</u>	2-5-314		2-8-374		2-8-194
	2-6-314	4G13695-101A	2-13-33	4G13782-101A	<u>2-10-14</u>
	2-7-314	4G13696-101A	2-5-378	4G13783-101A	2-10-15
	<u>2-8-314</u>		2-6-378	4G13784-101A	2-10-16
4G13617-101A	2-5-176		2-7-378	4G13790-101A	2-1-35
	2-6-176		2-8-378		2-5-145
	2-7-176				2-6-145
	2-8-176	4G13697-101A	2-13-23		2-7-145
4G13618-101A	2-5-178	4G13700-101A	2-10-17		2-8-145
	2-6-178	4G13701-101A	2-5-244	4G13791-101A	2-5-182
	2-7-178		2-6-244		2-6-182
	2-8-178		2-7-244		2-7-182
<u>4G13646-103B</u>	2-5-199		2-8-244		2-8-182
	2-6-199	4G13703-101A	2-10-49	4G13792-101A	2-5-187
	2-7-199	4G13706-101A	2-6-347C		2-6-187
	<u>2-8-199</u>		2-8-347C		2-7-187
4G13647-101A	2-9-16	4G13706-102A	2-6-347A		2-8-187
4G13648-101A	2-9-21		2-8-347A	4G13793-101A	2-5-273A
4G13648-103A	2-9-21	4G13708-101A	2-5-221		2-6-273
4G13649-105A	2-13-25		2-5-246		2-7-273A
			2-6-221D		2-8-273
4G13649-107A	2-13-25		2-6-246	4G13793-103A	2-5-273
4G13650-105A	2-13-27		2-7-221		2-6-273
4G13650-107A	2-13-27		2-7-246		2-7-273
4G13661-101A	2-5-232		2-8-221D		2-8-273
	2-6-232		2-8-246		
	2-7-232		2-15-107	4G13798-101A	2-5-106
	2-8-232	4G13717-101A	2-1-123		2-6-106
4G13662-101A	2-10-109	4G13720-101A	2-1-120		2-7-106
4G13665-103A	2-11-25	4G13725-101A	2-1-127		2-8-106
4G13666-101A	2-11-23		2-5-225	4G13799-101A	2-5-107
4G13667-101A	2-11-14		2-6-225		2-6-107
4G13668-101A	2-11-12		2-7-225		2-7-107
4G13669-101A	2-5-331		2-8-225		2-8-107
	2-6-331			4G13800-101A	2-5-133
	2-7-331	4G13729-103A	2-13-29		2-6-133
	2-8-331	4G13729-105A	2-13-29		2-7-133
4G13670-101A	2-11-21	4G13756-101A	2-13-3		2-8-133
4G13672-103A	2-12-5	4G13761-101A	2-5-274	4G13802-101A	2-5-102
4G13672-105A	2-12-5		2-6-274		2-6-102
4G13673-103A	2-12-6		2-7-274		2-7-102
4G13673-105A	2-12-6		2-8-274		2-8-102
4G13675-103A	2-12-9	4G13762-103A	2-13-24	4G13802-103A	2-5-103
4G13675-107A	2-12-10	4G13763-101A	2-13-30		2-6-103
4G13675-109A	2-12-9	4G13766-101A	2-5-190		2-7-103
	2-12-10		2-6-190		2-8-103
4G13676-101A	2-10-95		2-7-190	4G13803-101A	2-5-112
4G13677-101A	2-10-111	4G13767-101A	2-8-190		2-6-112
			2-5-192		2-7-112
4G13678-101A	2-11-24		2-6-192		2-8-112
4G13679-101A	2-10-73		2-7-192	4G13812-101A	2-1-46
4G13683-101A	2-5-310		2-8-192		2-11-2
		4G13768-103A	2-5-293	4G13813-101B	2-5-222

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
4G13813-101B	2-6-222		2-5-271	4G14389-101A	2-4-50
	2-7-222		2-6-271	4G14389-102A	2-4-50
	2-8-222		2-7-271	4G14390-101A	2-4-12
4G13864-101A	2-5-94		2-8-271	4G14391-101A	2-4-65
	2-6-94	4G14354-105A	2-1-64		2-5-371
	2-7-94		2-5-38		2-6-371
	2-8-94		2-6-38		2-7-371
		4G14354-107A	2-1-64		2-8-371
4G13879-101A	2-5-220		2-7-38	4G14392-101B	2-4-61
	2-6-220		2-8-38	4G14392-101B	2-5-367
	2-7-220	4G14355-101A	2-1-65		2-6-367
	2-8-220		2-5-39		2-7-367
4G13879-103A	2-5-221		2-6-39		2-8-367
	2-6-221	4G14355-103A	2-1-65	4G14393-101B	2-4-56
	2-7-221		2-7-39	4G14393-102B	2-4-56
	2-8-221		2-8-39	4G14394-101A	2-4-59
4G13904-101A	2-5-167	4G14356-101B	2-5-362		2-5-118
	2-6-167		2-6-362		2-6-118
	2-7-167		2-7-362		2-7-118
	2-8-167		2-8-362		2-8-118
4G13967-101A	2-5-398	4G14359-101A	2-1-50A		
	2-6-398		2-5-27	4G14396-101A	2-4-52
	2-7-398		2-5-365A	4G14406-101A	2-5-236
	2-8-398		2-6-27		2-6-236
4G13968-103A	2-5-391		2-6-365A		2-7-236
	2-6-391		2-7-27		2-8-236
	2-7-391		2-7-365A	4G14505-101A	2-9-5
	2-8-391		2-8-27	4G14506-101A	2-9-9
4G13970-101A	2-5-315		2-8-365A	4G14507-101A	2-9-7
	2-6-315			4G14508-101A	2-5-90
	2-7-315	4G14360-101A	2-5-261A		2-6-90
	2-8-315		2-6-261A		2-7-90
4G13988-101A	2-5-132		2-7-261A		2-8-90
	2-6-132		2-8-261A	4G14509-101A	2-5-88
	2-7-132	4G14361-101A	2-5-261C		2-6-88
	2-8-132		2-6-261C		2-7-88
4G13999-101A	2-5-1A		2-7-261C		2-8-88
	2-6-1A		2-8-261C	4G14510-101A	2-5-85
	2-7-1A	4G14362-101A	2-5-215T		2-6-85
	2-8-1A		2-5-261E		2-7-85
4G14122-101A	2-5-349		2-6-222A		2-8-85
	2-7-349		2-6-261E	4G14511-101A	2-5-89
4G14250-101A	2-1-40		2-7-261E		2-6-89
	2-5-159		2-8-261E		2-7-89
	2-6-159	4G14363-101A	2-5-261D		2-8-89
	2-7-158		2-6-261D	4G14512-101A	2-5-83
	2-7-159		2-7-261D		2-6-83
	2-8-159		2-8-261D		2-7-83
			2-1-56		2-8-83
4G14252-101A	2-1-5	4G14364-105A	2-1-56		
4G14255-101A	2-5-39	4G14364-107A	2-5-43	4G14515-101A	2-5-93
4G14270-101A	2-1-7		2-6-43		2-6-93
4G14281-101A	2-3-64		2-7-43		2-7-93
4G14299-101A	2-2-35		2-8-43		2-8-93
	2-3-35	4G14366-101A	2-1-57A	4G14551-101B	2-1-71
4G14299-102A	2-2-64		2-5-54		2-10-12
	2-3-63		2-6-54	4G14563-101A	2-5-215
4G14308-101C	2-1-19		2-7-54		2-6-215
4G14308-103C	2-1-23		2-8-54		2-7-215
4G14310-101A	2-2-4	4G14366-103A	2-1-58A		2-8-215
	2-3-4	4G14366-105A	2-1-58	4G14597-101A	2-12-13
4G14312-101A	2-2-9	4G14367-101A	2-1-70	4G14598-101A	2-12-11
	2-3-9		2-5-58	4G14599-101A	2-10-115
			2-6-58	4G14604-101A	2-10-117
4G14318-101A	2-1-6		2-7-58	4G14605-101A	2-5-297A
4G14319-101A	2-1-8		2-8-58		2-6-297A
4G14321-101A	2-1-26				2-7-297A
4G14322-101B	2-1-17	4G14368-101A	2-13-35		2-8-297A

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
4G14606-101A	2-9-14	4G19093-107A	2-8-301		2-6-72
4G14609-101A	2-12-3		2-6-387		2-7-72
			2-8-387	44C8MK2N	2-10-91
4G14620-101A	2-14-20	4G31003-101B	2-1-3	44C8MR2T	2-10-92
	2-16-		2-5-150		
4G14620-103A	2-16-3		2-6-150	44C8MTE160A	2-10-93
4G14621-101A	2-14-62		2-7-150	461101F06	2-2-2
	2-16-8		2-8-150	4661101F04	2-2-25
4G14621-103A	2-16-11	4G31003-103B	2-1-4	4661101F08	2-4-6
4G14622-101A	2-14-16		2-5-151	4671130F0404	2-2-25
	2-15-9		2-6-151	4671130F0606	2-2-2C
	2-16-16		2-7-151	4671133F040404	2-2-38
4G14622-103A	2-16-19		2-8-151	4671133F060604	2-1-126
4G14623-101A	2-15-52	4G53767-101A	2-10-94	4671133F080804	2-4-8
	2-16-26	4G53767-105A	2-10-46	4671138F060804	2-4-11
4G14623-103A	2-14-93	4G53767-109A	2-10-106		
	2-16-26	4G53787-101A	2-10-67	4671141F0404	2-2-40
4G14623-105A	2-16-28			4671143F0404	2-2-26
4G14624-101A	2-15-53	4G94025-103A	2-5-104A	4671143F0604	2-2-37
	2-16-36		2-6-104A	4671143F0606	2-2-2
			2-7-104A	4671143F0808	2-4-7
4G14624-103A	2-14-94		2-8-104A	4671145F0606	2-2-17
	2-16-36	4G94034-101B	2-5-381	4671146F040604	2-4-26
4G14624-105A	2-16-38		2-6-381	4671150F0808	2-4-25
4G14625-101A	2-15-54		2-7-381	467141F0606	2-2-2A
	2-16-44		2-8-381	467145F0404	2-2-21
4G14625-103A	2-14-95	4G94045-101A	2-10-28		
	2-16-44	4G94045-101B	2-10-28	49290	2-4-13
4G14625-105A	2-16-48	4G94406-101A	2-5-375	52RT02	2-5-384
4G14626-101A	2-15-55		2-6-375		2-6-384
	2-16-57		2-7-375		2-7-384
4G14626-103A	2-14-96		2-8-375		2-8-384
	2-16-57	4G94407-101A	2-10-66	55LH7644-108	2-5-168
4G14626-105A	2-16-60	4G94432-103A	2-5-318		2-6-168
4G14627-101A	2-15-45		2-6-318		2-7-168
	2-16-67		2-7-318	55LH7644-202	2-8-168
4G14627-103A	2-14-59		2-8-318		2-5-175
	2-16-67	4G94448-105A	2-10-45		2-6-175
		4G94448-105B	2-10-45		2-7-175
4G14627-105A	2-16-71	4G94449-101A	2-13-32		2-8-175
4G14633-101A	2-5-194A			55NE4717-162	2-5-165
	2-6-194A	404EN64-6	2-5-163		2-6-165
	2-7-194A		2-6-163		2-7-165
	2-8-194A		2-7-163		2-8-165
4G14634-101A	2-5-399		2-8-163	66C33001-03ST02	2-9-20A
	2-6-399	420-75-625SH	2-1-41	68030	2-4-35
	2-7-399		2-5-158		2-5-62
	2-8-399		2-6-158		2-6-62
4G14636-101A	2-5-388		2-7-158		2-7-62
	2-7-388		2-8-158		2-8-62
4G14637-101A	2-5-389	422EN1-12	2-4-62	68030-03	2-4-35
	2-7-389		2-5-368		2-5-62
4G14638-101A	2-6-389		2-6-368		2-6-62
	2-8-389		2-7-368		2-7-62
4G14639-101A	2-6-388		2-8-368		2-8-62
	2-8-388	42252D35	2-4-45A	68485-6-020	2-10-5
4G14647-101A	2-5-358		2-5-67	68485-8-024	2-10-10
	2-6-358		2-6-67		
	2-7-358		2-7-67	705617	2-1-13
	2-8-358		2-8-67		2-5-264
4G14648-101A	2-10-53	42252E220	2-5-70		2-6-264
4G19051-103A	2-10-109		2-6-70		2-7-264
			2-7-70		2-8-264
			2-8-70	7110FR-T	2-1-145
4G19063-101A	2-13-24	42252R15	2-4-41	7110FR-106A	2-1-146
4G19063-107A	2-5-301	42252R150	2-4-41	7110FR-160-T	2-1-144
4G19074-101A	2-6-301		2-8-72	7326-FTE-160-P5	2-10-105A
	2-7-301	42252R151	2-5-72	7326-FTE-964-470	2-10-105B

PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.	PART NUMBER	FIG & INDEX NO.
743133-002	2-4-45 2-5-67 2-6-67 2-7-67 2-8-67 2-10-93	7926446-10-30-50 79880	2-10-112 2-5-318 2-6-318 2-7-318 2-8-318 2-10-72 2-10-61A 2-10-59	8852948-01	2-5-291 2-6-291 2-7-291 2-8-291 2-5-291 2-6-291 2-7-291 2-8-291 2-5-161 2-6-161 2-7-161 2-8-161
744F8MTE-160-4780		8121312-01 8240768-01 8341160-01		8852948-03	2-5-291 2-6-291 2-7-291 2-8-291 2-5-161 2-6-161 2-7-161 2-8-161
745A2MT2N	2-10-41	8341169-01 8341169-10 8341244-01	2-10-61 2-10-58 2-5-317A 2-6-317A 2-7-317A 2-8-317A 2-13-9 2-13-9 2-13-17 2-13-17 2-10-98 2-10-98 2-5-293 2-6-293 2-7-293 2-8-293	9R2220-1	2-5-222W 2-7-222W 2-6-218F 2-8-218F 2-16-1 2-16-9 2-16-71 2-16-48 2-16-60 2-2-15A 2-3-15A
745A2MT987	2-10-42			9R2220-2	
7451FT160A	2-10-40	8412410-01 8412410-03 8412410-05 8412410-07 8412565-01 8412565-03 856081-01		9R2220-3	
7451FT2P3	2-10-39			300-452-5451-1004	
7729278	2-10-18			900-452-5451-1604	
7729278-90	2-10-18			900010-32C	
7729278-110	2-10-18			90725	2-13-32
7729278-120	2-10-18			9905-9	2-4-21
7729278-130	2-10-18			9906-9	2-4-20
7729278-150	2-10-18			9907-44	2-4-19
7729278-170	2-10-18				
7729790-01	2-12-1				
7829287-01	2-11-25				
78863	2-10-24				
78943	2-5-318 2-6-318 2-7-318 2-8-318 2-10-115 2-10-62	8631382-01 8742944-01	2-10-67 2-11-15		
7926422-01					
7926445					

C-5A M16 STRUT ASSEMBLY

BILL OF MATERIALS

17576A

72

STL-STEEL

AL-ALUMINUM

MG-MAGNESIUM

TIT-TITANIUM

SS-S STEEL

SYN-SYNTHETIC

LD-LEAD

C-5A INLG STRUT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	ITEM LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	YIELD OF MEAS	SCRAP TYPE R.D.C	PART MIC TYPE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH ORD NUMBER	PENDING ACTION	PENDING ACTION	PENDING ACTION	PENDING ACTION
	1..2	18412410-07	IN.S.L.	198747	...BUSHING, FLANGED DUAL FACE REPAIR	14										
	1..1	14613330-101A	11620001164434	198747	...SHAFT, UPPER SIDE BRACE	11	1EA									
	1..1	14613340-101A	15345002203152	198897	...RETAINER, SPLIT RING	11	1EA									
	1..1	14631800	15345002291255	198897	...RETAINING RING	12	1EA									
	1..1	14613337-101A	11620001164435	198897	...SHAFT, LOWER SIDE BRACE	11	1EA									
	1..1	14613341-101A	15345002203153	198897	...RETAINER, SPLIT RING	11	1EA									
	1..1	14634500	15345002291254	198897	...RETAINING RING	12	1EA									
	1..1	14613337-101A	11620001164433	198897	...BOLT, APEX	11	1EA									
	1..1	14613325-101A	15310001321826	198897	...WASHER	11	1EA									
	1..1	14613325-101A	15310002203018	198897	...NUT	11	1EA									
	1..1	14624665-439	15310002348770	196906	...COTTER, PIN	11	1EA									
	1..1	14611448-107A	11620001153450	198897	...RETRACT ARM ASSY	11	1EA									
	1..2	14633154-7	15310004024887	198897	...NUT	14	1EA									
	1..2	14614507-3	15310004028831	198897	...WASHER, SPECIAL	14	1EA									
	1..2	170361-1032	IN.S.L.	198897	...NUT	11										
	1..2	12230-7	15330005765121	198159	...SPECIAL WASHER W/PACKINGS	14	1EA									
	1..2	1463249-3	1531000366931	198897	...NUT	12	1EA									
	1..2	1463603-249	15305009720852	198897	...SCREW	12	1EA									
	1..2	14614505-105A	15340001008840	198897	...LOCK PLATE	11	1EA									
	1..2	14621250-07100	15306010818926	198897	...BOLT	14	1EA									
	1..2	14614507-101A	15340000476257	198897	...RETAINER	11	1EA									
	1..2	14615001-1	1473000504203	196906	...FITTING, LUBRICATION	11	1EA									
	1..2	14614506-101A	15340002655184	198897	...DIAPHRAGM	11	1EA									
	1..2	14628775-431	15330008473562	196906	...PACKING, PREFORMED	11	1EA									
	1..3	14611448-109A	IN.S.L.	198897	...RETRACT ARM	11										
	1..3	14613330-105A	13120010533044	198897	...BUSHING, FLANGED	11	1EA									
	1..3	14613329-103A	13120001357863	198897	...BUSHING, FLANGED	11	1EA									
	1..3	14613329-105A	13120010536147	198897	...BUSHING, FLANGED (O.S.)	11	1EA									
	1..3	14614606-101A	13120010536153	198897	...BUSHING, SLEEVE	12	1EA									
	1..3	146453001-035102	13120011791480	198747	...BUSHING, RIG PIN	12	1EA									
	1..3	14613347-101A	15306004541547	198897	...BOLT, TRUNNION CROSS PIN	12	1EA									
	1..1	14613346-101A	15345008338491	198044	...WASHER	12	1EA									
	1..1	14613346-101A	15310004839500	198897	...WASHER, KEY LOCK	12	1EA									
	1..1	14613332-101A	15310001351430	198897	...NUT, SPECIAL	12	1EA									
	1..1	14621392-2C13	15315008258657	196906	...CLEVIS PIN	12	1EA									
	1..1	14624665-132	15315008392329	196906	...COTTER, PIN	14	1EA									
	1..1	14624665-132	14010001702967	198897	...CABLE	12	1EA									
	1..1	14621256-1	15340006197031	196906	...CLIP	14	1EA									
	1..1	1462125185S	15340000679878	196906	...TURN BUCKLE BODY	12	1EA									
	1..1	14621252-5LS	15340000680531	196906	...CLEVIS	12	1EA									
	1..1	14620392-3C15	15315006426599	196906	...CLEVIS PIN	12	1EA									
	1..1	14614344-107A	11620010880616	198897	...PLATE ASSY	11	1EA									
	1..2	14621042-4	15310008071468	196906	...NUT, SELF LOCKING	11	1EA									





STL-STEEL  
AL-ALUMINUM  
HNS-NICKEL  
TIT-TITANIUM  
SS-6 STEEL  
SYN-SYNTHETIC  
LD-LEAD

C-5A M16 STRUT ASSEMBLY

## FILL OF MATERIALS

17576A

[illegible]

STEEL  
ALUMINUM  
MAGNESIUM  
TITANIUM  
SS-STEEL  
SYNTHETIC  
LEAD

C-3A NLG STRU i ASSEMBLY

## BILL OF MATERIALS

17576A

[illegible]

0109507/505

C-5A MUG STRUT ASSEMBLY

## BILL OF MATERIALS

17576A

STL-STEEL  
AL-ALUMINUM  
MAG-MAGNESIUM  
TITA-TITANIUM  
SS-S STEEL  
SYN-SYNTHETIC  
LD-LEAD

ROUTED ITEMS	FLOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER	UNIT OF	YIELD FACTOR	SCRAP R.D.C	PART TYPE	IMC CODE	REV LEVEL	EFFECTIVITY DATE	TECH NUMBER	ORD ACTION	PENDING ACTION	PENDING ACTION
1.1	14614390-101A	4620000035533	198897	1. VALVE	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	1462000045695	198906	1. PACKING, PREFORMED	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	14671138F060804	198897	1. TEE	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	14671138F060804	14730000506316	198897	1. TEE	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198747	1. TUBE L/H PLG ONLY	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198747	1. TUBE, DRAIN LINE	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198897	1. ELBOW	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. ELBOW	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. PACKING, PREFORMED	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	188055	1. NUT	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198747	1. TUBE L/H PLG ONLY	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198897	1. UNION	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198897	1. TEE	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	180205	1. BOLT SPECIAL	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198747	1. TUBE L/H PLG ONLY	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198747	1. TUBE L/H PLG ONLY	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198897	1. UNION	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198897	1. UNION	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198897	1. BRACKET L/H PLG ONLY	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198897	1. PIN, COVER	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198897	1. PIN, COVER	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198897	1. WASHER, FLAT	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198897	1. ROD, THREADED ENDS	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198897	1. BRACKET L/H PLG ONLY	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	180205	1. SCREW, MACHINE	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. NUT, SELF LOCKING	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	180205	1. SCREW, MACHINE	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	180205	1. SCREW, MACHINE	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. NUT	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	180205	1. SCREW, MACHINE	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1	1	1	1	1	1	1	1	1	1	1	1
1.1	146804105-113A	198906	1. CLAMP	1	1	1</											

C-SA M6 STRUT ASSEMBLY

17576A

STL-STEEL  
AL-ALUMINUM  
MAG-MAGNESIUM  
TITA-TITANIUM  
SS-8 STEEL  
SM-SYNTHETIC  
UP-LEAD

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	YIELD OF RATE	SCRAP FACTOR	PART TYPE	PHC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH NUMBER	DRD ACTION	PENDING 103	PENDING ACTION	PENDING AF TO 22 ACTION
1.2	4613672-105A		3120010539971	98897	CROSSPIN BUSHING O.S.	12	AREA				ALT						
1.2	4613673-103A		3120001793968	98897	BUSHING, FLANGED	16	EA										
1.2	4613673-105A		3120010539972	98897	BUSHING, FLANGED O.S.	16	AREA				ALT						
1.2	4613385-103A		3120002456469	98897	BUSHING, SLEEVE	12	EA										
1.2	4613385-105A		3120010536171	98897	BUSHING, SLEEVE O.S.	12	AREA				ALT						
1.2	4613382-103A		3120004437543	98897	BUSHING, FLANGED	12	EA										
1.2	4613382-105A		3120010546339	98897	BUSHING, FLANGED O.S.	12	AREA				ALT						
1.2	4613675-103A		3120001355645	98897	BUSHING, FLANGED	14	EA										
1.2	4613675-107A		3120012352131	98897	BUSHING, FLANGED O.S.	14	AREA				ALT						
1.2	4613675-109A		3120010562212	98897	BUSHING, FLANGED O.S.	14	AREA				ALT						
1.3	4614598-101A		3120010539970	98897	BUSHING, SPECIAL I.D.	11	EA										
1.3	2-171504-70		5330001521358	102697	PACKING, PREFORMED	11	EA										
1.1	815576-12		1620010064606	100293	ADAPTER	11	EA										
1.1	4612657-101A		1620001755395	98897	ELECT INSERT ASSY	11	EA										
1.1A	1621902-18		4730007201587	96906	BULKHEAD UNION	13	EA										
1.2	1622875-126		5330007021048	96906	PACKING, PREFORMED	16	EA										
1.2	1622877A-126		5330006009721	96906	RETAINER	12	EA										
1.2	4613988-101A		1620001994602	98897	CLIP, NYLON	14	EA										
1.2	4613800-101A		5315001308928	98897	PIN, RETAINER	14	EA										
1.2	11022150-1		5310000018383	62793	NUT, RETAINER	11	EA										
1.2	4612583-103A		1620001157419	98897	FLUID TRANSFER HSS ASSY	11	EA										
1.3	4614394-101A		1620001030976	98897	SPACER	11	EA										
1.3	4611019-107A		5365002356232	98897	SCREEN, MACHINE	12	EA										
1.3	16502-10-16		5305001509208	188044	SCREEN, MACHINE	12	EA										
1.4	468101		5340010812644	92555	PLUS, PIN (LEE)	15	EA										
1.4	478101		5340003694713	92555	PLUS, PIN (LEE) O.S.	15	AREA				ALT						
1.4	1621209F-1-15		5340008007874	96906	INSERT (HELICOID)	12	EA										
1.4	1621241-124012		3120005148651	96906	BUSHING, FABROID LINED (LB)	11	EA										
1.5	66C3000-53401		3120010697638	98747	SLEEVE (LG., RPR)	11	EA										
1.5	1621241-12406		IN.S.L.	.....*	BUSHING, FABROID LINED (LG RPR)	11	EA										
1.4	1621241-084012		3120004041675	96906	BUSHING, FABROID LINED (SM)	11	EA										
1.5	66C33000-57401		3120010728265	98747	SLEEVE (SM, RPR)	11	EA										
1.5	1621241-08406		IN.S.L.	.....*	BUSHING, FABROID LINED (SM RPR)	11	EA										
1.4	IN.P.L.		IN.S.L.	.....*	BUSHING, LOCK PINS (4130 STEEL)	14	ARI										
1.1	4669022-101A		5330001716444	98897	CORK GASKET	12	EA										
1.1	4669017-101A		5975001565734	98897	JUNCTION BOX R/H	11	EA										
1.1	4669016-102A		5975001565737	98897	JUNCTION BOX R/H	11	EA										
1.1	4669017-102A		5975001565731	98897	JUNCTION BOX L/H	11	EA										
1.1	4669016-101A		5975001565726	98897	JUNCTION BOX L/H	11	EA										
1.1	165603-30F		5305009270101	180205	SCREW, MACHINE	13	EA										
1.1	1653338-43		5310000453296	96906	WASHER, LOCK	13	EA										
1.1	16525082-3		5310000556930	96906	NUT	13	EA										
1.1	166735014		5340001930127	189144	CLAMP	12	EA										

b1dg5w7/505

C-5A MLG STRUT ASSEMBLY

17576A

STL-STEEL  
AL-ALUMINUM  
MAG-MAGNESIUM  
TITA-TITANIUM  
SS-S STEEL  
SYN-ARTIFICIAL  
LD-LEAD

[illegible]

## STARS

**ALUMINUM**

**WILSON**

57106111-061111  
T117A-T117AN(LN)

## TRIALS & TRIBES

## LINKS=4115

C-5A M16 STRUT ASSEMBLY

BILL OF MATERIALS

17576A

[illegible]

115744

[illegible]

## ଆଧାର

AL=ALUMINUM  
MAG=MAGNESIUM  
TITA=TITANIUM  
SS=STEEL  
SYN=SYNTHETIC  
LD=LEAD

U-SA MFG STRUCT ASSEMBLY

BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	DESCRIPTION	UNITS PER ASSY	YIELD FACTOR	PART R,D,C	INIC CODE	REV LEVEL	CONTROL DATE	NUMBER	PENDING ACTION	PENDING ACTION	PENDING ACTION
1.1	14604-109A	N.S.L.		98747	1. TUBE ASSY	1									
1.1	MS277-5A	5310008392017	80205	1. BAREL NUT		14	1EA								
1.1	4613710-101A	5365004375134	98897	1. SPACER		14	1EA								
1.1	MS2805-14	5305007283434	80205	1. SCREW, MACHINE		14	1EA								
1.1	12-019000606	4730004595055	111328	1. ELBOW, BULKHEAD 90 DEGREE		14	1EA								
1.1	AM974-60	5310006382605	88044	1. NUT		14	1EA								
1.1	12-03014506	5310001816038	98897	1. NUT		14	1EA			INT					
1.1	4613701-101A	1620004711178	98897	1. ROTATION MANIFOLD		11	1EA								
1.1	4511441-101A	1620001157412	98897	1. ROTATION MANIFOLD		11	1EA			INT					
1.1	MS2190214	4730007025377	96906	1. UNION		12	1EA								
1.1	MS28778-4	5330008052966	96906	1. PACKING PREFORMED		12	1EA			INT					
1.1	MS1009100410	4730001993607	98897	1. BULKHEAD TEE		11	1EA			INT					
1.1	MS28010	4730005857485	88044	1. NUT		12	1EA								
1.1	MS28773-10	5330005506743	96906	1. RETAINER PACKING		13	1EA								
1.1	MS28778-10	5330002859842	96906	1. PACKING, PREFORMED		12	1EA								
1.1	MS10081008	473000222357	98897	1. ELBOW		11	1EA								
1.1	1118-00011	4730004427239	79470	1. BOLT FLUID PASSAGE		11	1EA								
1.1	1118-00015	4730004636012	79470	1. CLUSTER NUT		11	1EA			SUB					
1.1	1118-00013	4730004427240	79470	1. CLUSTER 90 DEGREES		11	1EA								
1.1	1211FRT	5330004208236	72902	1. RETAINER, PACKING		14	1EA								
1.1	1211FRT160A	5330004210026	72902	1. PACKING, PREFORMED		12	1EA								
1.1	92220-2	4820003407186	99240	1. VALVE RESTRICTOR		11	1EA								
1.1	4613708-101A	1620001994597	98897	1. "L" BRACKET		12	1EA								
1.1	MS1305-150	530600780332	80205	1. BOLT		11	1EA								
1.1	MS6205-150	N.S.L.	80205	1. BOLT		11	1EA			INT					
1.1	MS1305-130	5306007217526	80205	1. BOLT		11	1EA								
1.1	MS6205-130	N.S.L.	80205	1. BOLT		11	1EA			INT					
1.1	MS1305-12	5306009438202	80205	1. BOLT		12	1EA								
1.1	MS1305-14	5306007208048	80205	1. BOLT		12	1EA								
1.1	4612399-101A	16500045581294E	98897	1. CROSSWIND POSIT MAN		11	1EA								
1.1	AF33-657-15053	4820004159968	34199	1. VALVE, RESTRICTOR		11	1EA								
1.1	209204	4820004839348	34199	1. VALVE RESTRICTOR		11	1EA								
1.1	MS28778-10	5330009316748	96906	1. PACKING, PREFORMED		11	1EA			INT					
1.1	AM960-516	5310001670820	88044	1. WASHER, FLAT		11	1EA								
1.1	MS21042-5	5310008071469	96906	1. NUT, SELF LOCKING		16	1EA								
1.1	ZZ266780	1650010486842	81873	1. SERVO VALVE		11	1EA								
1.1	MS26678-13	5305002070959	96906	1. SCREW ALLEN HEAD (SERVO ATTACH)		14	1EA								
1.1	MS21912-14	4730007021100	96906	1. BULKHEAD TEE		11	1EA								
1.1	MS28778-4	5330008052966	96906	1. PACKING PREFORMED		12	1EA								
1.1	MS2190214	4730007025377	96906	1. UNION		11	1EA								
1.1	MS28775-115	5330005797916	96906	1. PACKING, PREFORMED		13	1EA								
1.1	MS28775-115	5330011628702	96906	1. PACKING, PREFORMED		13	1EA			INT					
1.1	MS1305-101A	1620007201873	98897	1. CLUSTER 90 DEGREE		13	1EA								



## STL-STEEL

AL-ALUMINUM

MAG-MAGNESIUM

TITAN-TITANIUM

SS-S STEEL

SYN-SYNTHETIC

LM-LEAD

## C-5A NLG STRUT ASSEMBLY

## BILL OF MATERIALS

17576A

ROUTED	LOW LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS	UNIT YIELD	SCRAP	PART TYPE	REV	EFFECTIVITY	TECH	CHK	PENDING	PENDING
ITEMS	CODE					PER	OF	RATE	FACTOR	TYPE	CODE	LEVEL	NUMBER	ACTION	ACTION
1.1		AM9601216L	5310001670842	88044	WASHER, FLAT	13	TEA								
1.1		4612043-1018	1620002330758	98897	BRACKET, UNWHEELING	11	TEA								
1.1		4869151-115A	5340011601038	98897	ANGLE BRACKET	11	TEA								
1.1		M4S603-GP	5305008132796	80205	SCREW, MACHINE	11	TEA								
1.1		M527240-1	5930009723314	96906	SWITCH, UNWHEELING	11	TEA								
1.1		4869142-109A	162001161746	98897	CONDUIT	11	TEA								
1.1		M521908-10J	4730008258543	96906	ELBOW 90 DEGREES	11	TEA								
1.1		M521924J10	4730008271301	96906	UNION, BULKHEAD	13	TEA								
1.1		M521924J18	4730005266892	96906	UNION, BULKHEAD	13	TEA								
1.1		12-01096F0604	4730000935519	111328	BULKHEAD UNION	12	TEA								
1.1		AM924-80	5310002827835	88044	NUT	112	TEA								
1.1		12-01096F0806	4730002293010	111328	UNION, BULKHEAD	12	TEA								
1.1		12-01096F0604	4730000935519	111328	UNION, BULKHEAD	12	TEA								
1.1		12-01096F0606	4730002391144	111328	UNION, BULKHEAD	12	TEA								
1.1		ST98202JF080804	4730001443736	98897	BULKHEAD TEE	12	TEA								
1.1		174804104-105A	N.S.L.	98747	TUB ASSY	11									
1.1		174804104-113A	N.S.L.	98747	TUBE ASSY	11									
1.1		1582833J06	4730004333206	50948	ELBOW 90 DEGREES	12	TEA								
1.1		174804104-101A	N.S.L.	98747	TUBE ASSY	11									
1.1		174804101-211A	N.S.L.	98747	TUBE ASSY	11									
1.1		174804100-117A	N.S.L.	98747	TUBE ASSY (IN FLIGHT BRAKE)	11									
1.1		174804104-119A	N.S.L.	98747	TUBE ASSY	11									
1.1		174804104-121A	N.S.L.	98747	TUBE ASSY	11									
1.1		174804104-123A	N.S.L.	98747	TUBE ASSY	11									
1.1		AM924-10	5310002827832	88044	NUT	12	TEA								
1.1		AM960-01416	5310001872393	88044	WASHER, FLAT	14	TEA								
1.1		M521924J10	4730008271301	96906	BULKHEAD UNION	11	TEA								
1.1		AM6289J4	4730004536189	88044	NUT	14	TEA								
1.1		M528773-04	5330002466403	96906	RETAINER, PACKING	117	TEA								
1.1		AM960P0716	5310001670741	88044	WASHER, FLAT	13	TEA								
1.1		AM924-40	5310001596339	88044	NUT	18	TEA								
1.1		4612505-101A	4710010374600	98897	TUBE ASSY	11	TEA								
1.1		4612504-101A	N.S.L.	98747	TUBE ASSY	11									
1.1		M52191908G-4	5340002915323	96906	CLAMP	12	TEA								
1.1		M4S1103-2	5306006853605	80205	BOLT MACHINE	11	TEA								
1.1		ILSS984S3H	53100049419413	98897	WASHER, SPECIAL	11	TEA								
1.1		M521042-3	53100048071467	96906	NUT SELF LOCKING	11	TEA								
1.1		4612506-101A	N.S.L.	98747	TUBE ASSY	11									
1.1		14604104-149A	N.S.L.	98747	TUBE ASSY	11									
1.1		14604101-153A	N.S.L.	98747	TUBE ASSY	11									
1.1		M521912J4	4730007201100	96906	TEE	11	TEA								
1.1		AM960P0716	5310001670741	88044	WASHER, FLAT	11	TEA								
1.1		AM924-40	5310001596339	88044	NUT	11	TEA								

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C-SA MUG STRUT ASSEMBLY

17576A

[illegible]

U-5A MUG STRUT ASSEMBLY

17576A

STL=STEEL  
AL=ALUMINUM  
MAG=MAGNESIUM  
TITA=TITANIUM  
SS=S STEEL  
SYN=SYNTHETIC  
LD=LEAD

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT YIELD	SCRAP FACTOR	PART TYPE	MIC CODE	REV LEVEL	EFFECTIVITY CONTROL DATE	TECH CNG NUMBER	ORD ACTION	PENDING ACTION	PENDING 252	AFTD ACTION
1.1	179-50074	14720001162354	178286	178286	HOSE ASSY	1	1	1	1	1	1	1	1	1	1	1	1
1.1	179-50075	14720004562967	179470	179470	HOSE ASSY	1	1	1	1	1	1	1	1	1	1	1	1
1.1	4631003-1018	11620001790438	98897	98897	CROSSWIND CYL (R.E.)	1	1	1	1	1	1	1	1	1	1	1	1
1.1	4631003-1038	11620004427875	98897	98897	CROSSWIND CYL (CLEVIS)	1	1	1	1	1	1	1	1	1	1	1	1
1.1	46312433-101A	11620001177319	98897	98897	ANTI ROTATION BOLT ASSY	1	1	1	1	1	1	1	1	1	1	1	1
1.2	46316625-1137	15365007541083	96906	96906	SNAP RING	1	1	1	1	1	1	1	1	1	1	1	1
1.2	46313618-101A	15340012471999	98897	98897	DISC (GREASE SEAL)	1	1	1	1	1	1	1	1	1	1	1	1
1.2	46328775-017	15330006181920	96906	96906	PACKING, PREFORMED	1	1	1	1	1	1	1	1	1	1	1	1
1.2	46328775-017	15330011902750	96906	96906	PACKING PREFORMED	1	1	1	1	1	1	1	1	1	1	1	1
1.2	46313972-101A	11620002496046	98897	98897	PLUG, GREASE REATTINER	1	1	1	1	1	1	1	1	1	1	1	1
1.2	46315001-4	14730000504207	96906	96906	FITTING, LUBRICATION	1	1	1	1	1	1	1	1	1	1	1	1
1.2	46313617-101A	15310004563104	98897	98897	ANTI ROTATION WASHER	1	1	1	1	1	1	1	1	1	1	1	1
1.2	46314744-202	15310002440514	172962	172962	NUT	1	1	1	1	1	1	1	1	1	1	1	1
1.1	46311454-101D	11620001157413	98897	98897	NORMAL LOCK CYL	1	1	1	1	1	1	1	1	1	1	1	1
1.1	46314563-101A	116500113273371E	98897	98897	ENG LOCK CYL	1	1	1	1	1	1	1	1	1	1	1	1
1.1	46311104-130	15306006804225	180205	180205	BOLT	1	1	1	1	1	1	1	1	1	1	1	1
1.1	463120-4	15310001768108	180444	180444	NUT	1	1	1	1	1	1	1	1	1	1	1	1
1.1	463160-416	15310001411795	180444	180444	WASHER, FLAT	1	1	1	1	1	1	1	1	1	1	1	1
1.1	46324665-153	15315001850037	96906	96906	COTTER PINT	1	1	1	1	1	1	1	1	1	1	1	1
1.1	46313561-101A	15315001321925	98897	98897	APEX SHAFT	1	1	1	1	1	1	1	1	1	1	1	1
1.1	46314633-101A	14730011385377	98897	98897	SPECIAL BOLT	1	1	1	1	1	1	1	1	1	1	1	1
1.1	46313771-101A	14730001324076	98897	98897	SPECIAL BOLT	1	1	1	1	1	1	1	1	1	1	1	1
1.1	46313766-101A	15315001218807	98897	98897	PIN	1	1	1	1								

C-54 ML6 STRUT ASSEMBLY

# BILL OF MATERIALS

17576A

[illegible]

STL=STEEL  
AL=ALUMINUM  
MAG=MAGNESIUM  
TITA=TITANIUM  
SS=S STEEL  
SYN=SYNTHETIC  
LD=LEAD

C-5A ML6 STRUT ASSEMBLY

## BILL OF MATERIALS

17576A

[illegible]

bi005071505

C-5A ML6 STRUT ASSEMBLY

## BILL OF MATERIALS

## BILL OF MATERIALS

17576A

ROUTED	ITEMS	ITEM LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS	UNIT OF MEAS	PERCENT	YIELD	SCRAP	PART TYPE	INT CODE	REV LEVEL	EFFECTIVITY	TECH	ORD NUMBER	ACTION	PENDING	PENDING ACTION	PENDING ACTION
1.1			INFE5-3	13120001288990	15860	ROD END	EA														
1.1			INFE5-50	13120001288990	15860	ROD END	EA														
1.1			INFE559-1	15340005874173	180205	LOCK	EA														
1.1			INFE5-17	15306001511969	188044	BOLT	EA														
1.1			INFE520-3	15310002852177	188044	NUT	EA														
1.1			4611478-109A	11620003238292	198897	NORMAL ROTATION CYL	EA														
1.1			4611481-101C	11620002223887	198897	END ROTATION CYL	EA														
1.1			INFE2192A18	14730005260892	196906	UNION	EA														
1.1			INFE28778-8	15330012292234	196906	PACKING, PREFORMED	EA														
1.1			INFE2220-1	14820003407192	199240	RESTRICTOR VALVE	EA														
1.1			INFE147644-108	15310004600731	172962	NUT	EA														
1.1			4613370-101A	15310004045071	198897	SPACER	EA														
1.1			4613372-101A	15310004038303	198897	KEYED WASHER	EA														
1.1			4613904-101A	15310004103428	198897	SHIM	EA														
1.1			INFE4717-162	15310002211405	172962	NUT, SELF LOCKING	EA														
1.1			INFE24665-378	15315008994118	196906	DOTTER PIN	EA														
1.1			4613346-103B	15315001760762	198897	HEADLESS PIN	EA														
1.1			INFE1104-32	15306008273566	180205	BOLT	EA														
1.1			INFE21919005-8	15340002915347	196906	CLAMP	EA														
1.1			4614515-101A	11620001236738	198897	SYNCHRO TRANSMITTER	EA														
1.1			4613864-101A	15365001357882	198897	SHIM	EA														
1.1			INFE1304-6H	15306008081319	180205	BOLT	EA														
1.1			INFE607-11	15365003071035	136659	SPACER	EA														
1.1			INFE160-10	15310007225943	188044	WASHER	EA														
1.1			INFE23-23	15306001512302	188044	BOLT	EA														
1.1			INFE576864H	15310009619414	198897	WASHER	EA														
1.1			INFE500894	15975010045592	188044	WIRE TIE	EA														
1.1			INFE6763H680	15970000631495	126512	SHRINK TUBING 1/2"	EA														
1.1			INFE728-1-13																		

## C-5A PLB STRUT ASSEMBLY

## BILL OF MATERIALS

17576A

STL-STEEL  
AL-ALUMINUM  
MG-MAGNESIUM  
TI-TITANIUM  
SS-S STEEL  
SYN-SYNTHETIC  
LD-LEAD

ROUTED ITEMS	ILDM LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS PER ASSY	UNIT INCR	EFFECTIVITY DATE	TECH CONTROL	ORD NUMBER	PENDING ACTION	PENDING ACTION	PENDING ACTION
1.1		MS2191-905-8	534000725878	196906	CLAMP	110	EA						
1.1		MS6603-8P	5305000866937	180205	SCREW	117	EA						
1.1		MS21042-3	5310008071467	196906	NUT, SELF LOCKING	125	EA						
1.1		4611414-107A	11620004176249	198897	INNER CYLINDER ASSY	11	EA						
1.2		4611414-109A	IN.S.L.	198897	INNER CYLINDER	11	EA						
1.2		4613490-109A	11620002640758	198897	SADDLE BUSHING	11	EA						
1.2		4613490-117A	13120010539968	198897	SADDLE BUSHING O.S.	11	EA						
1.2		4613491-103A	13120001793975	198897	BUSHING	11	EA						
1.2		4613491-105A	13120010539967	198897	BUSHING O.S.	11	EA						
1.3		17926422-01	53100110184471E	198747	METERING TUBE BUSHING REPAIR	11	EA						
1.3		AS119	5330000976395	102289	PACKING PREFORMED	11	EA						
1.2		4614404-101A	13120010536148	198897	BUSHING, POSITIONER LUGS (RFR)	14	AR						
1.1		MS2178-2	5365005953911	188044	PLUG	11	EA						
1.1		MS2178-2	5330008037208	196906	PACKING, PREFORMED	11	EA						
1.1		120261SL475	11620001189624	110989	FILTER	11	EA						
1.1		MS6509-12	5310002989255	180205	NUT	11	EA						
1.1		MS2177A-364	5310004563095	198897	LOCKWASHER	11	EA						
1.1		MS2177A-364	5330000879975	196906	RETAINER	12	EA						
1.1		MS2177-49	53300007202130	188044	PACKING PREFORMED	11	EA						
1.1		MS21775-346	5330005793161	196906	PACKING, PREFORMED	11	EA						
1.1		4613320-101A	11620001233791	198897	CUP WASHER	11	EA						
1.1		MS2177-23	5330001965385	188044	PACKING PREFORMED	12	EA						
1.1		MS21775-218	5330005840263	196906	PACKING, PREFORMED	12	EA						
1.1		MS2177A-218	5330005822150	196906	RETAINER	12	EA						
1.1		4613319-101A	11620001233790	198897	METERING TUBE BASE	11	EA						
1.1		MS2177A-114	53300005763206	196906	RETAINER	12	EA						
1.1		MS2177-12	53300006183385	188044	PACKING, PREFORMED	11	EA						
1.1		MS21775-114	5330006 86-21	196906	PACKING, PREFORMED	11	EA						
1.1		4613390-101A	11620002284720	198897	UPPER METERING TUBE	11	EA						
1.1		4613310-101A	11620001233787	198897	LOWER METERING TUBE	11	EA						
1.1		4613495-101A	11620001522857	198897	PISTON RING	11	EA						
1.1		4613313-101A	15-5001436231	198897	LOCK PIN	11	EA						
1.1		4613312-101A	15-5001219452	198897	STOP RING	11	EA						
1.1		4613677-101A	5330001437175	198897	SQUARE PACKING	11	EA						
1.1		4613315-101A	5310004625222	198897	ROUND NUT	11	EA						
1.1		4612409-101A	11620001162100	198897	STOP TUBE ASSY	11	EA						
1.2		4612409-103A	11620001214199	198897	TUBE PISTON STOP	11	EA						
1.2		4615662-101A	5315001169447	198897	LOCATING PIN	11	EA						
1.1		4612409-101B	11620001299168	198897	STOP TUBE ASSY	11	EA						
1.2		4612409-103A	11620001214199	198897	TUBE PISTON STOP	11	EA						
1.2		4613662-101A	5315001169447	198897	LOCATING PIN	11	EA						
1.1		4613316-101A	5310004563093	198897	LOCKWASHER	11	EA						
1.1		1326421	5330000541387	172402	BACKUP RETAINER	14	EA						

## STATISTICS

C-5A ML6 STRUT ASSEMBLY

**WILSON**

# STIMULUS 30 T119

**III-III**

17576A

## Finals

LD=LEAD  
SYN=SYNT

[illegible]



Di005W715W5

**C-3A ML6 STRUT ASSEMBLY**

**WISCONSIN**

**आर्य समाज**

LD-45AD

## BILL OF MATERIALS

17576A

ROUTED ITEMS	LOW LEVEL CODE	PART NUMBER	STOCK NUMBER	VENDOR CODE	DESCRIPTION	UNITS PER ASSY	UNIT MEAS	YIELD FACTOR	SCRAP R.D.C	PART TYPE	PHC CODE	REV LEVEL	CONTROL DATE	EFFECTIVITY NUMBER	TECH ACTION	CHK 103	PENDING ACTION	252 ACTION	PENDING ACTION	AFTO 22
1.1	4613508-101A	1620001227973	98897	1	SHUBBER VALVE	1	EA													
1.1	4613507-101A	5365001227984LE	98897	1	SHUBBER SPACER	1	EA													
1.1	4613509-101A	5365001233784	98897	1	SHIM	1	EA													
1.1	4613504-101A	33120001321909	98897	1	BEARING SLEEVE	1	EA													
1.1	4613502-101A	5365001227966	98897	1	SHIM	1	EA													
1.1	4613503-101A	5310004617448	98897	1	LOCK (TAB) WASHER	1	EA													
1.1	4613499-101A	1620001227964	98897	1	RING, THREADED RETAINER	1	EA													
1.1	78863	N.S.L.	98897	1	THRUST RING	1	EA													
1.1	4694433-103A	1620001233783	98897	1	THRUST RING	1	EA													
1.1	1LS35196-1	5330005657043	98897	1	SEAL, PREFORMED	1	EA													
1.1	4611439-107B	1620003190461	98897	1	ROLL PIN ASSY	1	EA													
1.2	9615001-1	473000504203	96906	1	FITTING, LUBRICATION	1	EA													
1.3	4613544-103A	33120001313554	98897	1	BUSHING	1	EA													
1.3	4613407-103A	33120001313527	98897	1	BUSHING	1	EA													
1.3	N.P.L.	N.S.L.	98747	1	BUSHING, 7-FORT VALVE LUG (RPH)	1	EA													
1.3	4611439-109B	N.S.L.	98897	1	ROLL PIN	1	EA													
1.1	4611439-113A	1620001207984	98897	1	ROLL PIN ASSY	1	EA													
1.2	9615001-1	473000504203	96906	1	FITTING LUBRICATION	1	EA													
1.3	4613544-103A	33120001313554	98897	1	BUSHING	1	EA													
1.3	4613407-103A	33120001313527	98897	1	BUSHING	1	EA													
1.3	N.P.L.	N.S.L.	98747	1	BUSHING, 7-FORT VALVE LUG (RPH)	1	EA													
1.3	7729792-01	N.S.L.	98897	1	INBOARD SPACER (1ST D.S.)	1	EA													
1.4	7729792	33120010541204LE	84747	1	INBOARD SPACER BLANK	1	EA													
1.3	7729792-03	N.S.L.	98897	1	INBOARD SPACER (2ND D.S.)	1	EA													
1.4	7729792	33120010541204LE	84747	1	INBOARD SPAC															

## C-5A PLG STRUT ASSEMBLY

## BILL OF MATERIALS

17576A

STL-STEEL

AL-ALUMINUM

MAG-MAGNESIUM

TIT-TITANIUM

SS-S STEEL

SYN-SYNTHETIC

LD-LEAD

ROUTED	LOW LEVEL	PART NUMBER	STOCK NUMBER	VENDOR CODE	NOMENCLATURE	UNITS: UNIT	YIELD: SCRAP	PART TYPE	IMC	REV	EFFECTIVITY: TECH	ORD	PENDING	PENDING	PENDING
ITEMS	CODE					PER	OF RATE	FACTOR	R, D, C	LEVEL	CONTROL	DATE	NUMBER	ACTION	ACTION
1.1		4613492-101B	3120001357883	98897	BUSHING	14	EA								
1.1		5306001525509	5306001525509	98897	BOLT, CLOSE TOL	12	EA								
1.1		5306001525503	5306001525503	54878	BOLT, CLOSE TOL	12	EA			INT					
1.1		5310001499116	5310001499116	96906	WASHER	14	EA								
1.1		5310001670823	5310001670823	88044	WASHER	14	EA								
1.1		5310009618396	5310009618396	96906	NUT	12	EA								
1.1		5310001768112	5310001768112	88044	NUT	12	EA			INT					
1.1		5310001768110	5310001768110	88044	NUT	12	EA								
1.1		5315002341864	5315002341864	96906	COTTER PIN	12	EA								
1.1		11620010510374	11620010510374	98897	ROLL POSITIONER	12	EA								
1.1		4613726-101A	3120001313568	98897	BUSHING	14	EA								

# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

1046B-MM1-DY-MAT

0001

17575A CSA MLG 4G11020-107A

RCC MNPRA

4S1-93-3

84013

CH S S W F PF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STOR	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A PCT C
0001	JA	01	00		.92	PERCENT ENGR 56.1	MACHINE LOCK COLLAR GUIDE	.20			0
0010					.92		PART NUMBER/NSN	.000	.000		
0030	JA	01	15		.46	4G13569-101A	1620010751661	.077	.005		20
0010 E				RLG-RS-N3	1.00	NICK & BURR MED STRUT PART		.06711			
0020 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001			
0035	JA	01	15		.05		MACHINE LOCK RING SURFACE	.218	.009		34
0010 E				RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.09962			
0015 E				RLA-HP-C4	2.00	IRREG PART IN 4 JAW CHUCK	OCCURRANCED FOR 2 SIDES	.22097			
0020 E				RLA-FR-NG	2.00	FACE ROUGH 9 - 10 DIA. GRP 4	OCC FOR 12 INCH DIA	.04424			
0030 E				RLA-FF-NG	2.00	FACE FINISH 9 - 10 GROUP 4	OCC FOR 12 INCH DIA	.08910			
0040 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001			
0045	JA	01	00		1.00		HOLD FOR REASSY	.093	.000		46
0010 N					1.00		PLACE IN HOLDING AREA	.08300			
0020 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001			
9000	JA	01	15		.00		LABOR STANDARD HISTORY	.000	.000		0
0010						27AUG85	UPDATED OCCURANCE FACTORS/RESTRUCTURED				
0011							LABOR STANDARD TO MATCH AFLC FORM 958				
0012							WORK PREVIOUSLY DONE ON OPER. 80090				
0013							<OLD STANDARD> 13.42				
0020						31DEC85	UPDATED OCC FACTORS <OLD STD> 9.05				
900							N MONROE MANEAA 73357				

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/16/89  
481-93-3

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1445 PAGE 0001  
3

17575A C5A MLC 4611020-107A

ACC MNPRA

OPF

CH S S W F PF A/R REV

T K #R A FA SUPPORT

DOC

DESCRIPTION

BASE

CD

A

STEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

URS

DLY PCT C

RA033	S	E	JA	EA	1	J	B9037	.54	PERCENT ENGR 99.9	MACH D-5A MLC UPPER PLATE	3.68	1.99		
0001			JA	01	15			.00		PART NUMBER / NSN	.000	.000	0	
									4612423-101A	1620004182976				
0033			JA	01	15			.31		REPAIR SMALL SHAFT HOLE	.734	.262	7	
0010	E					KHM-SU-V1		.34	S/U VERT MILL BORE SMAL FXTA PRORATE 3 OPERATIONS	.50518	.197			
0020	E					RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS,	.08531	.098			
0030	E					RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD DIAL ALONG BASE	.07609	.087			
0040	E					RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD DIAL IN CENTER HOLE	.07609	.087			
0050	E					RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD MOVE TO SHL HOLE/CHK LOCATE	.07609	.087			
0060	E					RML-BB-AC		1.00	BORE HOLE 1 X 1 1/2 GROUP 2 ,	.23926	.275			
0070	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC,	.01001	.011			
0035			JA	01	15			.39		REPAIR LARGE SHAFT HOLES	1.049	.471	13	
0010	E					KHM-SU-V1		.34	S/U VERT MILL BORE SMAL FXTA PRORATE 3 OPERATIONS	.50518	.197			
0020	E					RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS,	.08531	.098			
0030	E					RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD DIAL IN BASE	.07609	.087			
0040	E					RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD DIAL IN CENTER HOLE	.07609	.087			
0050	E					RML-AL-AC		2.00	ALIGN HOLE TO SPINDLE ROD MOVE TO LRG HOLE 1/2 HOLES	.07609	.175			
0060	E					RML-BB-AC		2.00	BORE HOLE 1 X 1 1/2 GROUP 2 2 HOLES	.23926	.550			
0070	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC,	.01001	.011			
0037			JA	01	15			.77		REPAIR BEARING BORE	.733	.649	13	
0010	E					KHM-SU-V1		.34	S/U VERT MILL BORE SMAL FXTA PRORATE 3 OPERATIONS	.50518	.197			
0020	E					RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS,	.08531	.098			
0030	E					RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD DIAL IN CENTER HOLE	.07609	.087			
0040	E					RML-BB-AC		1.00	BORE HOLE 4 X 1 1/2 GROUP 2 BORE CENTER HOLE	.39012	.448			
0050	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC,	.01001	.011			
0038			JA	01	15			.46		REMOVE INSERTS	.156	.083	2	
0010	E					REW-SU-S1		.50	S/U FOR BENCH WORK GENERAL PRORATE 2 PARTS	.27525	.158			
0020	E					KER-AS-DA		4.00	REMOVE SPRING HELICAL 4 INSERTS	.00209	.009			
0030	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC,	.01001	.011			
0072			JA	01	15			.31		MACH SM. SHAFT HOLE BUSHING	.552	.197	5	
0010	E					RLA-SU-S3		.33	SET UP SMALL MEDIUM LATHE PRORATE 3 OPERATIONS	.49962	.189			
0020	E					RLA-HP-C1		1.00	1ST PART IN-OUT SCROLL CHUCK,	.01006	.011			
0030	E					KML-TA-CC		1.00	DIA .501-1.00 REM .033-.250 ,	.06699	.077			
0040	E					KML-TA-CD		1.00	DIA 1.0 REMOVE .250 ADD INCH TURN D.D.	.00947	.010			
0050	E					RLA-DR-EC		1.00	DRILL HOLE 1/2-2 DIA 1 - 1.5,	.06744	.077			
0060	E					RLA-BO-BA		1.00	BORE HOLE 1/2 TO 1 DIA 1 DP BORE BUSHING	.08663	.099			
0070	E					RLA-BO-BB		1.00	BORE HOLE 1/2 - 1 DIA ADD IN,	.01254	.014			
0080	E					RLA-FR-BA		1.00	FACE ROUGH 1/2 - 1 DIA GRP 1 FACE 1ST END	.01481	.017			
0090	E					RLA-FF-BA		1.00	FACE FINISH 1/2 - 1 GROUP 1 ,	.03023	.034			
0100	E					RLA-CO-BA		1.00	CUT OFF 1/2 - 1 DIA. GROUP 1,	.02742	.031			
0110	E					RLA-HP-C2		1.00	ADDITIONAL PART SCROLL CHUCK TURN PART AROUND IN CHUCK	.00640	.007			
0120	E					RLA-FR-BA		1.00	FACE ROUGH 1/2 - 1 DIA GRP 1 FACE 2ND END	.01481	.017			
0130	E					RLA-FF-BA		1.00	FACE FINISH 1/2 - 1 GROUP 1 ,	.03023	.034			
0140	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011			
0073			JA	01	15			1.00		INST SM.SHAFT HOLE BUSHING	.167	.193	5	
0010	E					REW-BU-S1		.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053			
0020	E					REW-BU-B2		.50	REBUSH A SET OF 2 BOSSES 1 STRAIGHT BUSHING	.22231	.127			
0030	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011			
			JA	01	15			.39		MACH LG. SHAFT HOLE BUSHING	.929	.417	11	

0010 E	RLA-SU-S3	.33	SET UP SMALL MEDIUM LATHE	PRORATE 3 OPERATIONS	.49962	.169		
0020 E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	2 BUSHINGS	.01006	.023		
0030 E	KML-TA-C0	2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06689	.154		
0040 E	KML-TA-C0	2.00	DIA 1.0 REMOVE .250 ADD INCH	2 BUSHINGS	.00947	.021		
0050 E	RLA-DR-EC	2.00	DRILL HOLE 1/2-2 DIA 1 - 1.5	2 BUSHINGS	.06744	.155		
0060 E	RLA-BO-BA	2.00	BORE HOLE 1/2 TO 1 DIA 1 OF	2 BUSHINGS	.03663	.177		
0070 E	RLA-BO-BB	2.00	BORE HOLE 1/2 - 1 DIA ADD IN	2 BUSHINGS	.01254	.028		
0080 E	RLA-FR-BA	2.00	FACE ROUGH 1/2 - 1 DIA GRP 1	FACE 1ST END 2 BUSHINGS	.01481	.034		
0090 E	RLA-FF-BA	2.00	FACE FINISH 1/2 - 1 GROUP 1	2 BUSHINGS	.03023	.069		
0100 E	RLA-CO-BA	2.00	CUT OFF 1/2 - 1 DIA. GROUP 1	2 BUSHINGS	.02752	.063		
0110 E	RLA-HP-C2	2.00	ADDITIONAL PART SCROLL CHUCK	TURN PART AROUND IN CHUCK	.00640	.014		
0120 E	RLA-FR-BA	2.00	FACE ROUGH 1/2 - 1 DIA GRP 1	FACE 2ND END 2 BUSHINGS	.01481	.034		
0130 E	RLA-FF-BA	2.00	FACE FINISH 1/2 - 1 GROUP 1		.03023	.069		
0140 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001	.011		
0075	JA 01	15	1.00	INST LG. SMALL HOLE BUSH	.278	.042	.321	9
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669	.053		
0020 E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.22231	.255		
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001	.011		
0076	JA 01	15	.77	MACH BEARING BORE BUSHING	.669	.077	.593	16
0010 E	RLA-SU-S3	.33	SET UP SMALL MEDIUM LATHE	PRORATE 3 OPERATIONS	.49962	.169		
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK,		.01006	.011		
0030 E	KML-TA-GE	1.00	DIA 3.00-4.00 REM .251-.500		.09425	.108		
0040 E	KML-TA-GF	1.00	DIA 4.0 REM .500 ADD INCH	TURN O.D.	.01762	.020		
0050 E	RLA-DR-EC	1.00	DRILL HOLE 1/2-2 DIA 1 - 1.5,		.06744	.077		
0060 E	RLA-BO-GA	1.00	BORE HOLE 3 - 3 1/2 DIA 1 DP BORE BUSH.		.13261	.152		
0070 E	RLA-BO-GB	1.00	BORE HOLE 3-3.5 DIA. ADD IN		.04189	.048		
0080 E	RLA-FR-GA	1.00	FACE ROUGH 3 - 4 DIA. GRP 1	FACE 1ST END	.01545	.017		
0090 E	RLA-FF-GA	1.00	FACE FINISH 3 - 4 GROUP 1		.03150	.036		
0100 E	RLA-CO-GA	1.00	CUT OFF 3 - 3 1/2 DIA. GRP 1		.03007	.034		
0110 E	RLA-HP-C2	1.00	ADDITIONAL PART SCROLL CHUCK	TURN PART AROUND IN CHUCK	.00640	.007		
0120 E	RLA-FR-GA	1.00	FACE ROUGH 3 - 4 DIA. GRP 1	FACE 2ND END	.01545	.017		
0130 E	RLA-FF-GA	1.00	FACE FINISH 3 - 4 GROUP 1		.03150	.036		
0140 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001	.011		
0077	JA 01	15	1.00	INST BEARING BORE BUSHING	.167	.025	.193	5
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669	.053		
0020 E	RBW-BU-B2	.50	REBUSH A SET OF 2 BOSSES	1 STRAIGHT BUSHING	.22231	.127		
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001	.011		
0078	JA 01	15	.62	INSTALL INSERTS	.431	.040	.308	8
0010 E	RBW-SU-H1	1.00	SET UP TO INSTALL HELICOILS		.31093	.357		
0020 E	RBW-TA-H1	4.00	INSTALL HELICOIL INSERT	4 INSERTS	.02763	.127		
0030 E	RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001	.011		
9000	JA 01	15	.00	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				15OCT85 UPDATED OCCURANCE FACTOR/RESTAURMED				
0011				LABOR STD TO MATCH AFLC FORM 100				
0012				<OLD STD> .40				
0020				22JAN86 UPDATED OCC FACTORS <OLD STD> 1.00				
0900				NED MONROE MANEAA 73357				

TO INTERROGATE LABOR STANDARDS, INPUT

END NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 02/15/90  
RCC MNPA 4S1-90

A-E0468-MM1-DY-M45 PAGE 0001  
84013

17575A CSA MLG 4G11020-107A

OPER	4 S S	W F PF A/R REV			OCC	DESCRIPTION	BASE	PFD	STD	A
SU	T K	#R A FA SUPPORT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C	
STEP	D L	K C DC ELEMENT								
RA012	S E	JA EA 1	J 89017	.13	PERCENT ENGR 99.9	MACH LOWER PLATE C-5A M	.61		.34	
0001		JA 01 00		.00	PART NUMBER/NSN		.000	.000	.000	0
		0010			4G13558-101A 1620004212101					
0040		JA 01 15		.33	SHAFT HOLE REP (SMALL)		.734	.036	.279	11
0010 E		KMH-SU-V1		.34	S/U VERT MILL BORE SMAL FXTRPRORATE 3 OPERATIONS		.50518		.197	
0020 E		RHL-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS,		.08531		.098	
0030 E		RHL-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD DIAL ALONG BASE		.07609		.087	
0040 E		RHL-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD DIAL IN CENTER HOLE		.07609		.087	
0050 E		RHL-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD MOVE TO SHL HOLE/CHK LOCATE		.07609		.087	
0060 E		RHL-BB-AC		1.00	BORE HOLE 1 X 1 1/2 GROUP 2 ,		.23926		.275	
0070 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC,		.01001		.011	
0050		JA 01 15		.33	SHAFT HOLE REP (LARGE)		1.049	.052	.398	15
0010 E		KMH-SU-V1		.34	S/U VERT MILL BORE SMAL FXTR PRORATE 3 OPERATIONS		.50518			
0020 E		RHL-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS,		.08531		.098	
0030 E		RHL-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD DIAL IN BASE		.07609		.087	
0040 E		RHL-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD DIAL IN CENTER HOLE		.07609		.087	
0050 E		RHL-AL-AC		2.00	ALIGN HOLE TO SPINDLE ROD MOVE TO LRG HOLE/2 HOLES		.07609		.175	
0060 E		RHL-BB-AC		2.00	BORE HOLE 1 X 1 1/2 GROUP 2 2 HOLES		.23926			
0070 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC,		.01001		.011	
00		JA 01 15		.33	BEARING BORE REP		.734	.036	.279	11
0010 E		KMH-SU-V1		.34	S/U VERT MILL BORE SMAL FXTRPRORATE 3 OPERATIONS		.50518			
0020 E		RHL-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS,		.08531			
0030 E		RHL-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD DIAL ALONG BASE		.07609		.087	
0040 E		RHL-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD DIAL IN CENTER HOLE		.07609		.087	
0050 E		RHL-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD MOVE TO SHL HOLE/CHK LOCATE		.07609		.087	
0060 E		RHL-BB-AC		1.00	BORE HOLE 1 X 1 1/2 GROUP 2 ,		.23926		.275	
0070 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC,		.01001		.011	
0065		JA 01 15		.05	REMOVE INSERTS		.156	.001	.007	0
0010 E		RBW-SU-G1		.50	S/U FOR BENCH WORK GENERAL PRORATE 2 PARTS		.27525		.158	
0020 E		KER-AS-DA		4.00	REMOVE SPRING HELICAL 4 INSERTS		.00209		.009	
0030 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC,		.01001		.011	
0118		JA 01 15		.33	MACH SHAFT HOLE BUSH (SMALL)		.211	.010	.080	3
0010 E		RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS		.49962		.143	
0020 E		RLA-HP-C1		1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030 E		KHL-TA-CC		1.00	DIA .501-1.00 REM .033-.250		.06699		.077	
0040 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0120		JA 01 15		.33	INST SHAFT HOLE BUSH (SMALL)		.077	.004	.029	1
0010 E		RBW-BU-S1		.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS		.18669		.053	
0020 E		RBW-BU-A4		1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0121		JA 01 15		.33	FINISH MACH SHL HOLE BUSH		.640	.032	.243	9
0010 E		KMH-SU-V1		.25	S/U VERT MILL BORE SMAL FXTRPRORATE OVER 4 PARTS		.50518		.145	
0020 E		RHL-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E		RHL-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RHL-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RHL-BA-CD		1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE		.21626		.248	
0060 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
00		JA 01 15		.33	MACH SHAFT HOLE BUSH (LRG)		.211	.010	.080	3
0010 E		RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS		.49962		.143	
0020 E		RLA-HP-C1		1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030 E		KHL-TA-CC		1.00	DIA .501-1.00 REM .033-.250		.06699		.077	
0040 E		RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0130		JA 01 15		.33	INST SHAFT HOLE BUSH (LRG)		.211	.010	.080	3

0030 E	KML-TA-CC	1.00 DIA .501-1.00 REM .033-.250	.06077	.077	
0040 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
JA 01	15	.33 FINISH MACH	.606	.030	.230 9
10 E	KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTMPROPRATE OVER	.50515		.145
020 E	RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS	.08331		.098
0030 E	RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD	.12699		.146
0040 E	RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD	.07609		.087
0050 E	KMM-BA-AC	1.00 BORE HOLE 1 X 1 1/2 GROUP 1 USE PROPER	.18220		.209
0060 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011
0138	JA 01	15 .67 MACH BEARING	.240	.024	.185 7
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	.49962		.143
0020 E	RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK	.01006		.011
0030 E	KML-TA-6C	1.00 DIA 3.00-4.00 REM .033-.250	.07800		.089
0040 E	KML-TA-6D	1.00 DIA 4.0 REM .250 ADD INCH	.01707		.019
0050 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011
0140	JA 01	15 .67 INST BEARING	.077	.008	.060 2
0010 E	RBW-BU-S1	.25 SET UP TO REDUSH BOSSES	.18662		.053
0020 E	RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING	.02062		.023
0030 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011
0141	JA 01	15 .67 FINISH MACH	.650	.005	.501 19
0010 E	KMM-SU-V1	.25 S/U VERT MILL BORE SMAL FXTMPROPRATE OVER	.50		.145
0020 E	RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS	.08331		.098
0030 E	RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD	.12699		.146
0040 E	RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD	.07609		.087
0050 E	KMM-BA-FC	1.00 BORE HOLE 3.5 X 1.5 GROUP 1 USE PROPER	.22574		.259
0060 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011
0145	JA 01	15 .33 INSTALL INSERT	.431	.021	.164 6
0010 E	RBW-SU-H1	1.00 SET UP TO INSTALL HELICOILS	.31093		.357
0020 E	RBW-TR-H1	4.00 INSTALL HELICOIL INSERT	.02		.127
0030 E	RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC	.01001		.011
9000	JA 01	15 .00 LABOR STAN	.000	.000	.000 0
0010		15OCT85 UPDATED OCCURANCE FACTOR/RESTRICTION			
0011		LABOR STD TO MATCH AFLC FORM 90			
0012		<OLD STD> .75			
0020		30DEC85 UPDATED FACTORS <OLD STD>			
0900		N MONITOR MANEAA 73357			

INTERROGATE LABOR STANDARDS. INPUT

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC MNPRB

4S1-93-3

84013

CH S S W F PF A/R REV

T K #R A FA SUPPORT

OCC

&lt;-----

DESCRIPTION

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BASE

PFD

STD

A

STEP D L K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

RB032	S	E	JA	EA	3	J	85345	.67	PERCENT ENGR 99.9	GRND COLLAR LOCK RING C5	2.55		1.71		
0001			JA	01	00			1.00		PART NUMBER/NSN	.000	.000	.000		0
0010									4G13412-101A	1620001357841					
0070			JA	01	15			.63		GRIND FACE OF TEETH	.556	.053	.403		16
0010	E						RGR-SU-S1	.50	SET UP SURFACE GRINDER	PRORATE 2 PARTS	.04390		.025		
0020	E						KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0030	E						RLA-HP-C6	1.00		LOAD PART ON SURFACE GRINDER	.02466		.028		
0040	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0050	E						KMG-OD-TA	1.00	GRIND .010 FROM 12 D X 1		.38100		.438		
0060	E						RLG-EI-C3	2.00	CHK FACE TO FACE I/S OR O/S MIC 2 TIMES		.01427		.032		
0070	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0075			JA	01	15			.63		CHAMFER EDGES OF TEETH	.193	.018	.140		5
0010	E						RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.158		
0020	E						RLG-RS-N4	1.00		CHAMFER EDGE OF TEETH	.04595		.052		
0030	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080			JA	01	15			.56		1ST GRIND SHOULDER	.919	.077	.592		23
0010	E						RGR-SU-C2	1.00	SET UP SMALL MED CYL GRINDER		.29197		.335		
0020	E						RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E						KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E						KMG-OD-TA	1.00	GRIND .010 FROM 12 D X 1		.38100		.438		
0070	E						RLG-EI-C3	2.00	CHK FACE TO FACE I/S OR O/S MIC 2 TIME7		.01427		.032		
0080	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090			JA	01	15			.56		1ST GRIND MAJOR DIA	.919	.077	.592		23
0010	E						RGR-SU-C2	1.00	SET UP SMALL MED CYL GRINDER		.29197		.335		
0020	E						RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E						KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E						KMG-OD-TA	1.00	GRIND .010 FROM 12 D X 1		.38100		.438		
0070	E						RLG-EI-C3	2.00	CHK FACE TO FACE I/S OR O/S MIC 2 TIMES		.01427		.032		
0080	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0204			JA	01	15			.63		FINISH GRIND MAJOR DIA	1.141	.108	.827		32
0010	E						RGR-SU-C2	1.00	SET UP SMALL MED CYL GRINDER		.29197		.335		
0020	E						RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030	E						RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040	E						KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060	E						KMG-OD-TA	1.00	GRIND .040 FROM 12 IN D X 1		.41901		.711		
0070	E						RTL-MM-M3	2.00	MIC O D FIRST MEASUREMENT	MIC 2 TIMES	.00616		.014		
0080	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01	15			.01		LABOR STANDARD HISTORY	.000	.000	.000		0
0010									11DEC85 RESTRUCTURED LABOR STD TO MATCH AFLC FORM						
0011									958/UPDATED OCC FACTOR/WORK PREVIOUSLY						
0012									DONE ON OPER A0210 <OLD STD> 2.49						
0900									N MONROE MANEA 73357						

TO INTERROGATE LABOR STANDARDS. INPUT

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-MM1-DY-M45

PAGE 0001

17575A CSA MLG 4G11020-1071

RCC MNPRA

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84013

OP	CH	S	S	W	F	P	F	A/R	REV	TK	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C					
RA032	E	N	JA	EA	1	J	88280	1.00	PERCENT ENGR 3.8	MACH COLLAR LOCK RING C5	.26		.26							
0001			JA	01	00		1.00		PART NUMBER/NSN	.000	.000	.000		0						
0010								4G13412-101A	1620001357841											
0315			JA	01	00		1.00		ASSY COLLAR	.260	.000	.260		100						
0010	N						1.00		ASSY COLLAR	.25000		.250								
0020	E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010								
9000			JA	01	00		.00		LABOR STANDARD HISTORY	.000	.000	.000		0						
0010								9 JUNE 88 INITIAL INPUT MRPII												
0900								NED MONROE HANEL 73255 MR BIG												

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# FILE OF MATERIALS

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# FAMILY 7

CONTROL NUMBER LIST

LABO TECH	PLAN TECH	CONTROL NUMBER	JOP DESC	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	G01 FLO DAY
BENT	COOP	17467A		KC-135 MLG	TORSION LINK	1620-00-650-9335	5-72334-9	44A-12-3	410
BENT	POLL	17474A✓-6		T-38 MLG	STRUT ASSY L/H	1620-00-264-0744	7227217-10	4S1-75-73	45
BENT	POLL	17476A -6		T-38 MLG	STRUT ASSY R/H	1620-00-279-5839	7227217-20	4S1-75-13	45
BENT	POLL	17478A✓-6		T-38 MLG	STRUT ASSY	1620-00-299-0278	7227219-10	4S2-62-3	30
COOP	COOP	17494A -6		F-15 MLG	ORIFICE TUBE	1620-00-300-4145	68A410726-2001	4S2-73-3	60
COOP	COOP	17517A		F-15 MLG	ORIFICE TUBE	1620-00-348-6405	68A410726-1001	44A-22-3	30
BENT	TOLH	17527A		A-7D MLG	STRUT ASSY	1620-01-006-3237	986100-509	4S1-90-3	30
DELE		17541A		F-111 MLG	BRACE	1620-00-948-8182	10 OCT 88	44A-15-3	20
BENT	POLL	17546A		F-5/T-38	SIDE BRACE	1620-00-140-5241	6-40650-513	4SA6-11-3	30
BENT	POLL	17547A		F-5/T-38	SIDE BRACE	1620-00-140-5242	6-40650-514	4SA6-11-3	30
COOP	POLL	17565A✓-6		C-141 MLG	STRUT ASSY	M 1620-01-020-4973	3610005-125	4S1-73-3	35
BENT	COOP	17567A -6-J		KC-135 MLG	STRUT ASSY	M 1620-01-030-1912	7327025-50	4S2-30-3	37
JENS	POLL	17568A		F-5/T-38	SIDE BRACE TRUNNION	1620-00-007-1783	1440695-1	4SA6-11-3	
COOP	POLL	17574A✓-6-J		C-141 MLG	CRANK ASSY	1620-00-397-7413	7430178-30	4S2-59-3	46
MONR	ANDE	17575A✓-6		C-5 MLG	STRUT ASSY R/H AFT	M 1620-01-005-4191	4611020-107A	4S1-93-3	34
MONR	ANDE	17576A✓-6		C-5 MLG	STRUT ASSY L/H AFT	M 1620-01-005-4192	4611020-105A	4S1-93-3	34
MONR	ANDE	17577A✓-6		C-5 MLG	STRUT ASSY L/H FWD	M 1620-01-005-4193	4611020-101A	4S1-93-3	34
MONR	ANDE	17578A✓-6		C-5A MLG	STRUT ASSY RH FWD	M 1620-01-005-4194	4611020-103A	4S1-93-3	34
BENT	TOLH	17595A -6		A-7D MLG	STRUT ASSY	M 1620-00-837-2427	986100-505	4S1-90-3	30
JENS	COOP	17652A -6		F-106 MLG	STRUT ASSY "A" N	1620-00-569-5209	578600-501	4S2-40-3	
BENT	TOLH	17654A -6		F-106 MLG	SIDE BRACE	1620-00-633-2808	578350-501	4S1-32-13	25
COOP	TOLH	17662A -6		F-111 MLG	STRUT ASSY SHOCK	1620-01-066-8945	7327074-110	4S1-78-3	44
COOP	TOLH	17663A -6		F-111 MLG	STRUT ASSY-SHOCK	1620-01-066-8946	7729961-10	4S1-78-3	44
COOP	TOLH	17664A		F-111 MLG	STRUT ASSY-SHOCK	1620-01-070-0632	7729961-30	4S1-78-3	44
COOP	TOLH	17677A		F-111 MLG	STAB. ROD	1620-00-422-1839	12L9593-701	44A-19-3	15
BENT	TOLH	17681A		A-7D MLG	STEERING LINK ASSY	1620-00-168-5519	215-24041-6	44A-27-3	10
BENT	TOLH	17685A -6		F-106 MLG	STRUT ASSY "B"	1620-00-082-0821	634600-50	4S2-50-3	55
COOP	POLL	17686A		C-141 MLG	LINK ASSY	1620-00-281-0622	3611092-101	4S1-73-3	20
MONR	ANDE	17687A -6		C-5A MLG	INNER CYLINDER	1620-01-000-5925	7926445	4S1-93-3	31
DELE		17693A		E-3A MLG	LOWER LINK	1620-01-007-4262	30 NOV 87	44A-24-13	
DELE		17696A		E-3A MLG	TORSION LINK	1620-01-009-0007	30 NOV 87	4S1-107-3	
DELE		17702A		E-3A MLG	TORSION LINK	1620-01-010-6718	30 NOV 87	44A-24-13	
DELE		17708A		E-3A MLG	DAG STRUT	1620-01-016-4227	30 NOV 87	4S1-107-3	
DELE		17709A		E-3A MLG	TRUCK ASSY	1620-01-016-4228	30 NOV 87	44A-25-3	
DELE		17711A		E-3A MLG	BEAM ASSY	1620-01-018-1601	30 NOV 87	4S1-105-3	
DELE		17754A		E-3A MLG	STRUT ASSY R/H	1620-01-009-0003	30 NOV 87	4S1-102-3	
BENT	COOP	17757A -J		KC-135 MLG	BOLT TRUNNION	4730-00-758-6711LE	69-30734-1	44A-12-24	20
DELE		17759A		F-15	BUNGEE ASSY	1620-00-333-7134	8 AUG 86	44A-22-3	
DELE		17816A -6		F-111 MLG	BRACE LOMER	1620-00-225-1854	10 OCT 88	44A-18-3	25
DELE		17857A		E-3A MLG	TRUNNION L/H	1620-01-015-5021	30 NOV 87	4S1-107-3	
MART	SHEL	17874A		F-15	LOADER L/H 340 MM	1010-00-314-3246	7329956	11M2-52-62	10
MART	SHEL	17921A		F-16	DRUM ASSY 12 INCH	1005-01-044-6174	132D1869	11M1-7-16-2	15
MART	SHEL	17945A			GRENADE LAUNCHER 40 MM	1010-00-129-6447	11838703	11M3-9-4-2	4
DELE		17952A		E-3A MLG	BRAKE SUPPORT COLLAR	1620-01-019-9813	30 NOV 87	4S1-107-3	
DELE		17953A		E-3A MLG	BRAKE EQUALIZER ROD	1620-01-015-9814	30 NOV 87	4S1-107-2	
DELE		17954A		E-3A MLG	BRAKE EQUALIZER ROD	1620-01-015-9815	30 NOV 87	4S1-107-3	
JENS	PRIC	17964A -J		F-15 MLG	WHEEL	1630-01-071-6112	5004395	4M3-8-23	16
COOP	TOLH	18076A -6-J		F-111 MLG	STAB ROD	3040-00-161-4005	12L10030-707	44A-17-3	12
DELE		18077A			LINKER DELINKER M284-1	4925-00-420-2970	19 NOV 86	34Y36-1-1	
DELE		18097A			POD ADAP	1560-00-350-7021BF	20 NOV 86		

PROD NSR	RCC	OPER NSR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
17771	MKPRW	XKPRW	X	4N	5	.54	1.00	54
FAMILY 7 C-5 MLG								54
	MNPC=	HB374	N	HP	6	.93	1.00	93
		HC305	N	HC	6	5.05	1.00	5.05
		HC363	N	H3	5	5.29	1.00	5.29
		HP305	N	3S	5	1.10	1.00	1.10
*								12.37
	MNPCK	00100	N	YF	1	4.00	1.00	4.00
		XNPCK	X	YA	6	30.00	1.00	30.00
*								34.00
	MNPGP	00010	N	YK	5	110.60	1.00	110.60
		PAG20	N	YK	5	46.40	1.00	46.40
		PD058	N	YK	5	126.02	1.00	126.02
		PD374	E	YK	5	.02	1.00	2
		PM045	N	YK	5	.50	1.00	50
		PM058	N	YK	5	8.92	1.00	8.92
		PM088	E	YK	5	1.03	1.00	1.03
		PP001	E	3S	5	2.51	1.00	2.51
		PP005	E	3S	5	.54	1.00	54
		PP006	E	3S	5	.42	1.00	42
		PP009	E	3S	5	.40	1.00	40
		PP011	E	3S	5	.89	1.00	89
		PP013	E	3S	5	1.20	1.00	1.20
		PP014	E	3S	5	.35	1.00	35
		PP015	E	3S	5	1.22	1.00	1.22
		PP016	E	3S	5	.81	1.00	81
		PP017	E	3S	5	.54	1.00	54
		PP018	E	3S	5	1.61	1.00	1.61
		PP019	E	3S	5	.35	1.00	35
		PP020	E	3S	5	.40	1.00	40
		PP021	E	3S	5	.40	1.00	40
		PP024	E	3S	5	1.13	1.00	1.13
		PP025	E	3S	5	.52	1.00	52
		PP026	E	3S	5	.40	1.00	40
		PP034	E	3S	5	.54	2.00	1.08
		PP038	E	3S	5	.54	1.00	54
		PP048	E	3S	5	.54	1.00	54
		PP053	E	3S	5	.54	.58	31
		PP059	N	3S	5	.41	1.00	41
		PP060	E	3S	5	.40	1.00	40
		PP062	E	3S	5	.70	1.00	70
		PP062	E	3S	5	1.23	1.00	1.23
		PP091	E	3S	5	.54	1.00	54
		PP092	E	3S	5	.54	1.00	54
		PP093	E	3S	5	.54	1.00	54
		PS000	N	YK	5	.50	1.00	50
		PS001	N	YK	5	.25	1.00	25

(G4024-TIP001)

LABOR STD REVIEW 10 APR 89

4:37 PM

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
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17575A	MNPGP	PS014	N	YK	5	1.21	1.00	1.21
		PS015	N	YK	5	.25	1.00	.25
		PS045	N	YH	5	2.00	1.00	2.00
		PS048	N	YK	5	.40	1.00	.40
		PS059	N	YK	5	.55	1.00	.55
		PS062	N	HF	5	.25	1.00	.25
		PS088	N	YK	5	7.60	1.00	7.60
		XNPGP	X	SS	5	19.64	1.00	19.64

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349.17

MNPGW	WC001	N	KI	5	16.41	1.00	16.41
	WE001	E	DI	5	.94	1.00	.94
	WE002	N	DI	5	4.32	1.00	4.32
	WE005	N	DI	5	.28	1.00	.28
	WE006	N	DI	5	.28	1.00	.28
	WE007	E	DI	5	.42	1.00	.42
	WE009	N	DI	5	.22	1.00	.22
	WE011	N	DI	5	.18	1.00	.18
	WE012	N	DI	5	.30	1.00	.30
	WE013	E	DI	5	.49	1.00	.49
	WE014	N	DI	5	.53	1.00	.53
	WE015	E	DI	5	1.16	1.00	1.16
	WE016	N	DI	5	.37	1.00	.37
	WE017	N	DI	5	.19	1.00	.19
	WE018	E	DI	5	.69	1.00	.69
	WE019	N	DI	5	.44	1.00	.44
	WE020	N	DI	5	.19	2.00	.38
	WE021	N	DI	5	.41	1.00	.41
	WE024	N	DI	5	.19	1.00	.19
	WE025	N	DI	5	.19	1.00	.19
	WE026	N	DI	5	.27	1.00	.27
	WE031	N	DI	5	.15	1.00	.15
	WE032	N	DI	5	.28	1.00	.28
	WE033	N	DI	5	.30	1.00	.30
	WE034	N	DI	5	.17	2.00	.34
	WE035	N	DI	5	.15	1.00	.15
	WE036	N	DI	5	.18	1.00	.18
	WE037	N	DI	5	.34	1.00	.34
	WE038	N	DI	5	.19	1.00	.19
	WE039	N	DI	5	.17	1.00	.17
	WE040	N	DI	5	.27	1.00	.27
	WE041	N	DI	5	.15	1.00	.15
	WE043	N	DI	5	.26	1.00	.26
	WE046	N	DI	5	.29	1.00	.29
	WE047	N	DI	5	.27	1.00	.27
	WE048	N	DI	5	.25	1.00	.25
	WE049	N	DI	5	.15	1.00	.15
	WE051	N	DI	5	.38	1.00	.38
	WE052	N	DI	5	.25	1.00	.25
	WE053	N	DI	5	.25	1.00	.25
	WE055	N	DI	5	.15	1.00	.15
	WE060	N	DI	5	.15	1.00	.15

(G402A-TIP001)

LABOR STD REVIEW 12, APR, 89

4:38 PM

								FACTORED
PROD NR	RCC	OPER NR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	STAND HOURS
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17575A	MNPSW	WE062	N	DI	5	.26	1.00	26
		WE061	N	DI	5	.30	1.00	30
		WE092	N	DI	5	.29	1.00	29
		WE093	N	DI	5	.30	1.00	30
		XNPSW	X	HE	5	6.06	1.00	6.06
								-----
								40.90
								-----
	MNPMG	XNPMG	X	JB	1	2.00	.10	20
								-----
								20
								-----
	MNPMN	MN062	N	JA	1	1.00	1.00	1.00
								-----
								1.00
								-----
	MNPNM	NA001	E	DS	2	4.52	1.00	4.52
		NA002	E	DS	2	1.95	1.00	1.95
		NA005	E	DS	2	.56	1.00	56
		NA006	E	DS	2	.53	1.00	53
		NA007	E	DS	2	1.60	1.00	1.60
		NA009	E	DS	2	.50	1.00	50
		NA011	E	DS	2	.10	.95	9
		NA012	E	DS	2	.33	.11	3
		NA013	E	DS	2	.22	1.00	22
		NA014	E	DS	2	.54	1.00	54
		NA015	E	DS	2	.55	1.00	55
		NA016	E	DS	2	.59	.69	40
		NA017	E	DS	2	.11	1.00	11
		NA018	E	DS	2	.90	1.00	90
		NA019	E	DS	2	.15	1.00	16
		NA020	E	DS	2	.15	2.00	32
		NA021	E	DS	2	.47	1.00	47
		NA024	E	DS	2	.20	2.00	40
		NA025	E	DS	2	.17	1.00	17
		NA026	E	DS	2	.75	1.00	78
		NA031	E	DS	2	.06	1.00	6
		NA032	E	DS	2	.11	1.00	11
		NA033	E	DS	2	.34	1.00	34
		NA034	E	DS	2	.17	2.00	34
		NA035	E	DS	2	.05	1.00	6
		NA036	E	DS	2	.09	1.00	9
		NA037	E	DS	2	.14	.63	8
		NA038	E	DS	2	.75	.07	5
		NA041	E	DS	2	.37	1.00	7
		NA043	E	DS	2	.15	1.00	15
		NA047	E	DS	2	.33	1.00	33
		NA048	E	DS	2	.07	1.00	7
		NA049	E	DS	2	.26	.05	1
		NA051	E	DS	2	.14	1.00	14
		NA052	E	DS	2	.34	1.00	34
		NA053	E	DS	2	.33	.16	5
		NA060	E	DS	2	.10	.63	6

(G402A-TIP001)

LABOR STD REVIEW 10 APR 90

4:33 PM

PROD NSR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
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17576A	MNPNA	NA002	E	03	2	.19	1.00	19
		NA305	E	03	2	.52	1.00	53
		NA303	E	03	2	.08	1.00	3
		XNPNA	X	03	2	7.33	1.00	7.33

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25.38

	MNPRA	RA000	E	JA	1	1.60	.25	40
		RA001	E	JA	1	33.65	.79	26.58
		RA002	E	JA	1	22.13	.67	14.82
		RA007	E	JA	1	.05	.25	1
		RA009	E	JA	1	5.33	.63	3.70
		RA012	E	JA	1	2.62	.13	34
		RA013	E	JA	1	6.79	.50	3.39
		RA014	E	JA	1	7.35	.67	4.92
		RA015	E	JA	1	45.96	.79	37.09
		RA016	E	JA	1	2.41	.52	1.39
		RA017	E	JA	1	.54	.67	36
		RA018	E	JA	1	7.34	.83	5.09
		RA021	E	JA	1	1.50	.54	86
		RA024	E	JA	1	.54	1.00	54
		RA025	E	JA	1	.54	.08	4
		RA026	E	JA	1	1.41	.63	88
		RA030	N	JA	1	3.55	.41	1.45
		RA031	N	JA	1	.20	.92	18
		RA032	N	JA	1	.26	1.00	26
		RA033	E	JA	1	3.69	.54	1.99
		RA034	E	JA	1	3.00	.06	13
		RA038	E	JA	1	4.70	.09	42
		RA041	E	JA	1	.27	.35	4
		RA043	E	JA	1	1.11	.09	9
		RA047	E	JA	1	.00	.13	1
		RA048	E	JA	1	3.08	1.00	3.08
		RA049	N	JA	1	.11	1.00	11
		RA051	E	JA	1	.54	.79	42
		RA059	N	JA	1	1.15	1.00	1.15
		RA091	N	JA	1	3.41	.15	51
		RA092	N	JA	1	3.41	.05	17
		RA093	N	JA	1	3.41	.15	51

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111.98

	MNPRA	R3001	E	JA	3	29.29	.79	23.13
		R3002	E	JA	3	23.19	.67	15.53
		R3005	E	JA	3	3.73	.17	64
		R3006	E	JA	3	4.29	.21	1.02
		R3007	E	JA	3	1.66	1.00	1.66
		R3014	E	JA	3	5.75	1.00	5.75
		R3015	E	JA	3	4.05	.20	81
		R3016	E	JA	3	7.95	.58	4.61
		R3017	E	JA	3	2.36	.17	35
		R3018	E	JA	3	8.51	.17	1.41
		R3019	E	JA	3	10.23	.05	51

PROJ NR	RCL	OPER NR	TYP STD	SK	FAC	STAND HOURS	FACTORED	
							OCC FAC	STAND HOURS
17576A	MNPR8	R3020	E	JA	3	1.78	1.00	1.78
		R3024	E	JA	3	3.36	.50	1.68
		R3025	E	JA	3	3.42	.29	1.00
		R3032	E	JA	3	2.55	.67	1.70
		R3034	E	JA	3	2.30	.41	1.14
		R3043	N	JA	3	.60	1.00	.60
		R3051	E	JA	3	1.76	.79	1.59
		R3053	E	JA	3	1.28	.50	.64
		XNPR8	X	JA	3	.03	1.00	.03
								65.38
	MNPRC	RC001	N	UP	3	11.64	1.00	11.64
		RC002	N	UP	8	21.37	1.00	21.37
		RC005	E	UP	8	1.25	.71	.88
		RC006	E	UP	8	1.33	.75	.99
		RC007	E	UP	3	3.05	1.00	3.05
		RC009	N	UP	3	1.30	.63	1.13
		RC011	E	UP	8	.64	.21	.13
		RC012	E	UP	8	.19	.38	.07
		RC013	E	UP	3	2.34	.18	.42
		RC014	N	UP	8	6.40	1.00	6.40
		RC015	E	UP	8	4.51	1.00	4.51
		RC016	E	UP	8	3.16	.63	1.99
		RC017	N	UP	3	1.16	.67	.77
		RC018	E	UP	2	2.82	.84	2.36
		RC019	E	UP	3	2.50	.16	.36
		RC020	N	UP	3	1.41	1.50	2.11
		RC021	E	UP	8	1.94	.79	1.53
		RC024	E	UP	8	.87	.35	.73
		RC025	N	UP	2	1.47	.75	1.16
		RC026	E	UP	3	1.73	.67	1.15
		RC032	N	UP	3	2.18	1.00	2.18
		RC033	E	UP	3	.62	.54	.33
		RC034	N	UP	8	3.15	.97	3.05
		RC035	E	UP	3	.66	1.00	.66
		RC036	E	UP	3	1.28	.79	1.01
		RC037	E	UP	3	.69	1.63	1.12
		RC038	E	UP	8	.96	.50	.48
		RC039	E	UP	2	.14	.21	.02
		RC040	E	UP	3	.14	.05	.05
		RC043	E	UP	3	.41	.21	.08
		RC046	E	UP	8	.17	.13	.02
		RC047	E	UP	8	.75	.17	.12
		RC048	E	UP	3	1.43	1.00	1.43
		RC049	E	UP	8	.56	.23	.46
		RC051	N	UP	8	1.59	.63	1.00
		RC052	E	UP	8	.36	.16	.05
		RC053	N	UP	3	2.41	.56	1.39
		RC060	E	UP	3	.64	.13	.08
		RC062	E	UP	3	1.22	.54	.65
		RC091	E	UP	3	.33	.50	.19
		RC092	E	UP	3	.38	.50	.19



(G402A-TIP001)

LABOR STD REVIEW 10 APR 89

4:38 PM

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	CCC FAC	FACTORED STAND HOURS
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175754	MNPRC	RC093	E	UP	3	.32	.05	1
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77.80

MNPSA	XNPSA	X	43	S	5.00	1.00	5.00
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5.00

MNPWW	W-048	N	WF	9	1.14	1.00	1.14
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WH091	N	WL	A	.57	1.00	.57
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WH092	N	WF	A	.57	1.00	.57
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WH093	N	WF	A	.57	1.00	.57
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2.55

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726.57

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES C-5A MAIN		11. STOCK NUMBER		12. OPTIONAL 48-1-182 8 DWG 4611415 481-93-3 AND SUPPLEMENTS					
13. SERIAL NUMBER		14. NOUN OUTER CYLINDER							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
P/N 4611415	5-107A	NSN 1620004463776 C/N 17575A 17576A 17577A 17578A 72879A							
		***** UNIT COST: \$59055.05 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3 FPI IAW MIL-STD-883C FMPI IAW MIL-STD-1949 P/O N01561 STRIP CHROME IAW MIL-STD-871 GRIND IAW MIL-STD-866 TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165 CHROME PLATE IAW MIL-STD-1501 P/O N61891 CAD PLATE IAW MIL-STD-870 TYPE II CLASS II BRUSH PLATE IAW MIL-STD-865 BAKE IAW 48-1-182 MADI 74-12 BLAST IAW MIL-STD-1504 IVD IAW MIL-C-83488A ALODINE IAW MIL-C-5541 *****MAT'L 300M (280-300 KSI)***** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21001N			
		B		D					

21001N

10A

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 2 OF 2 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
---------------	-------------	------------------

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4011415-107A			
	005 *REQD*	DISASSEMBLE/REMOVE ALL BUSHINGS *C/P MOVE		001 MNPBP 002 01 003 SD03	
	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPBW 002 03 003 SLD1	
	*REQD*	BLAST CLEAN *C/P MOVE		001 MNPBW 002 03 003 BL01	
	*REQD*	BAKE 4 HRS AT 350-400F		001 MNPBW 002 03 003 BK03	
		DATE IN _____ TIME IN _____			
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL					
13. SERIAL NUMBER		14. NOUN							
		OUTER CYLINDER							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		[REDACTED] *C/P MOVE				M	001 MNPNA		
	*REQD*						002 05		
							003 ML01		
		[REDACTED] DEGREASE AFTER MAG					001 MNPE	07	
	*REQD*						002 06		
							003 MUD1		
8	020	CHECK CONCENTRICITY OF DIAMETER "C" TO DIAMETER "B". MAXIMUM 0.003 TIR. RECORD ACTUAL READING					001 MNPRB		
	*REQD*	I.D. 7.724/7.727/7.729 WEAR					002 01		
		RECORD DIMENSION					003 GI01		
		*C/P MOVE					005 X8745221		
							006 X8745223		
8	025	CHECK CONCENTRICITY OF COLLAR AREA O.D. TO DIA "C" MAXIMUM 0.003 TIR. RECORD ACTUAL READING					001 MNPRB		
	*REQD*	*C/P MOVE					002 01		
							003 GI01		
							005 X8745221		
							006 X8745223		
8	030	CHECK CONCENTRICITY OF UPPER BORE I.D. TO DIA "A" MAXIMUM .005 TIR. RECORD ACTUAL READING					001 MNPRB		
	*REQD*	*C/P MOVE					002 01		
							003 GI01		
							005 X8745221		
							006 X8745223		
8	035	CHECK CONCENTRICITY OF LOWER BORE I.D. TO DIA "A". MAXIMUM OF .005 TIR. RECORD ACTUAL READING					001 MNPRB		
	*REQD*	*C/P MOVE					002 01		
							003 GI01		
							005 X8745221		
							006 X8745223		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21001N			
		B		D					

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 4 OF 4 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		E AND I INSPECTION ***NOTE*** IF AREA "C" HAS FLASH CHROME (.0007 FROM FACTORY) AND IS WITHIN .006 TIR, INITIATE 150 FOR USE AS IS. *CHECK & RECORD CONCENTRICITY BETWEEN UPPER & LOWER BORE I.D. AREA "C" 7.724/7.727 WEAR 7.729 CYLINDER O.D. 12.496/12.499 WEAR 12.490 CYLINDER ID LOWER BORE 11.874/11.878 WEAR 11.882 CYLINDER ID UPPER BORE 11.746/11.756 WEAR 11.760 RECORD BASE METAL DIMENSION POSITIONING LUG BUSHING I.D. 1.624/1.626 WEAR 1.628 CROSSWIND LUG BUSHING FACE TO FACE 2.185/2.188 WEAR 2.183 BASE METAL 2.310 MAX RECORD BASE METAL DIMENSIONS LEFT RIGHT BALLSCREW HOLE BUSHING I.D. 2.749/2.751 WEAR 2.752 BASE METAL 4.100 MAX RECORD BASE METAL DIMENSIONS LEFT RIGHT BALLSCREW CROSS PIN HOLE BUSHING I.D. 1.600/1.602 WEAR 1.6035 BASE METAL 1.900 MAX RECORD BASE METAL DIMENSIONS LEFT RIGHT RETAINER RING GROVE ID 12.057/12.062 WEAR 12.064 ROTATION LUG BUSHING ID 1.937/1.9385 WEAR 1.9395 BASE METAL UPPER LEFT 2.210 MAX RECORD BASE METAL DIMENSIONS		001 MNPBW 002 04 003 EID1	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	

109

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 5 OF 5 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		LOWER LEFT 2.280 MAX RECORD BASE METAL DIMENSIONS			
		UPPER RIGHT 2.280 MAX RECORD BASE METAL DIMENSIONS			
		LOWER RIGHT 2.210 MAX RECORD BASE METAL DIMENSIONS			
		AREA C OVERALL LENGTH 3.860/3.845			
		MANIFOLD LUG BUSHING ID .323/.326 WEAR .329 BASE METAL .500 MAX			
		UPPER END THRUST BEARING FROM TOP 2.660/2.670 WEAR 2.659 NOTE: A MINIMUM OF TWO FMPI'S REQUIRED ON THIS PART			
8	050	GRIND CHAMFER TO REMOVE CHROME BETWEEN FACE & AREA "C" .090 X 30 DEG *C/P MOVE		001 MNPRE 002 01 003 GP01 005 X8745129	
26	052	VAPOR DEGREASE *C/P MOVE		001 MNPRE 002 03 003 DG01	
26	053	STRIP CAD *C/P MOVE		001 MNPRE 002 02 003 CS01	
26	054	STRIP RUST *C/P MOVE		001 MNPRE 002 02 003 CS02	
26	055	GRIT BLAST UPPER BORE & DOME AREA TO REMOVE MINOR CORROSION & DAMAGE NOT EXCEEDING .005 IN DEPTH OR 15% TOTAL SURFACE AREA *C/P MOVE		001 MNPRE 002 01 003 BL02	
		LOCAL REWORK I.D. .030 DEPTH X 1.0 WIDTH X 3.0 LENGTH IAW FIG 5-48 *C/P MOVE		001 MNPRE 002 04 003 EI01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 6 OF 6 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	065	STRIP CHROME FROM CYLINDER O.D. *C/P MOVE		001 MNPRC 002 02 003 SC02 <del>005 X7432930</del>	
26	070	STRIP CHROME FROM UPPER BORE I.D. *C/P MOVE		001 MNPRC 002 02 003 SC02 <del>005 X7432930</del>	
26	075	STRIP CHROME FROM LOWER BORE I.D. *C/P MOVE		001 MNPRC 002 02 003 SC02 <del>005 X7432930</del>	
26	080	STRIP CHROME FROM I.D. OF "C" AREA IF FACE IS NOT CHROME PLATED *C/P MOVE		001 MNPRC 002 02 003 SC02 <del>005 X7432930</del>	
86	085	FIRST GRIND CYLINDER O.D. MIN O.D. 12.476 RECORD BASE METAL DIMENSIONS *C/P MOVE		001 MNPRB 002 03 003 GG02	
8	090	FIRST GRIND UPPER BORE I.D. MAX I.D. 11.770 MAINTAIN 0.005 TIR WITH DIA "A" RECORD TIR RECORD BASE METAL DIMENSIONS *C/P MOVE		001 MNPRB 002 01 003 GI01 <del>005 X8745221</del> 006 X8745223	
8	100	FIRST GRIND LOWER BORE I.D. MAX I.D. 11.892 TO BE CONCENTRIC WITH DIA "A" MAXIMUM OF .005 TIR RECORD TIR RECORD BASE METAL DIMENSIONS *C/P MOVE		001 MNPRB 002 01 003 GI01 <del>005 X8745221</del> 006 X8745223	
8	105	IF OPERATION .020 READING IS MORE ? THAN 0.003 OR DIA "C" DOESN'T MEET TECH ORDER REQUIREMENTS, FIRST GRIND (CONTINUED)		001 MNPRB 002 01 003 GP01 <del>005 X8745180</del>	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	

HL

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 7 OF 7 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		AREA "C" TO REMOVE CHROME MAX I.D. 7.739 MAINTAIN 0.003 TIR WITH UPPER BORE. THIS OPERATION WILL NOT BE REQUIRED IF 150 HAS BEEN INITIATED PER OPERATION 045. RECORD TIR. MAKE SURE ALL CHROME IS REMOVED FROM CHAMFER			
		*****NOTE***** * IF I.D. DOES NOT EXCEED 7.729 * WITH A 32 RMS FINISH NO CHROME * IS REQUIRED.!!!!!! *****			
		RECORD BASE METAL DIMENSION *C/P MOVE			
86	110	HONE LOWER BORE TO REMOVE DEFECTS RECORD BASE METAL DIMENSION *C/P MOVE		001 MNPRB 002 03 003 HV04 005 XB745197	
86	113	LOCAL REWORK I.D. .030 DEPTH X 1.0 WIDTH X 3.0 LENGTH, IAW FIG 5-48 IF HONE DOES NOT CLEAN UP, IN LOWER BORE *C/P MOVE		001 MNPRB 002 03 003 BE01	
86	115	HONE UPPER BORE TO REMOVE DEFECTS RECORD BASE METAL DIMENSIONS *C/P MOVE		001 MNPRB 002 03 003 HV04 005 XB745197	
36	118	LOCAL REWORK I.D. .030 DEPTH X 1.0 WIDTH X 3.0 LENGTH, IAW FIG 5-48 IF HONE DOES NOT CLEAN UP IN UPPER BORE *C/P MOVE		001 MNPRB 002 03 003 BE01	
69	120	SECOND REPAIR AREA "C" ID BORE ID MIN ID 7.844/7.984 MAINTAIN 0.003 TIR WITH UPPER BORE RECORD TIR		001 MNPRB 002 02 003 MH05 005 XB733672	
		MAX ID 7.984 MIN WALL .607 RECORD BASE METAL DIMENSIONS *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	



## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 8 OF 8 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69	121	CHECK & RECORD DIMENSIONS ON ATTACHED SHEET (INITIAL) *REQD* *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X833672		
69	125	COLLAR AREA O.D. REPAIR MIN O.D 8.965 CONCENTRIC TO DIA "C" WITHIN .003 TIR RECORD TIR _____ RECORD BASE METAL DIMENSION _____ *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X833672		
69	130	REPAIR COLLAR FACE. MACHINE TO 3.710 MIN. FOR BUSHING I.A.W. T.O. 451-93-3. RECORD REQD FLANGE THICKNESS ON OPERATION 425. *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X833672		
69	135	MACHINE SHOULDER OF THRUST BEARING AREA O.D. MIN WALL THK .700 MAINTAIN .380 RADIUS RECORD REQD WASHER THICKNESS ON OPERATIONS 420 & 432 * C/P MOVE					001 MNPRA 002 02 003 MH05 005 X833672		
69	140	BALLSCREW HOLE REPAIR (RIGHT SIDE) MAX I.D. 4.100 RECORD CRITICAL DIMENSION _____ *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X833672		
69	145	BALLSCREW HOLE REPAIR (LEFT SIDE) MAX I.D. 4.100 RECORD CRITICAL DIMENSION _____ *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X833672		
69	150	BALLSCREW HOLE FACE REPAIR RIGHT SIDE MATERIAL REMOVAL .080/.150 RECORD REQD FLANGE THICKNESS ON OPERATION 475 *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X833672		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21001N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1969-008-113

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 9 OF 9 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 P	20 Q
69	155	BALLSCREW HOLE FACE REPAIR LEFT SIDE MATERIAL REMOVAL .080/.150 RECORD REQD FLANGE THICKNESS ON OPERATION 470 *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8433672	
69	160	BALLSCREW CROSS PIN HOLE REPAIR (LEFT SIDE) MAX I.D. 1.900 RECORD BASE METAL DIMENSION *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	165	BALLSCREW CROSS PIN HOLE REPAIR (RIGHT SIDE) MAX I.D. 1.900 RECORD BASE METAL DIMENSION *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	170	CROSSWIND LUG HOLE REPAIR (LEFT SIDE) MAX I.D. 2.310 RECORD BASE METAL DIMENSION RECORD REQD FLANGE THICKNESS ON OPERATION 426 *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8433672	
69	175	CROSSWIND LUG HOLE REPAIR (RIGHT SIDE) MAX I.D. 2.310 RECORD BASE METAL DIMENSION RECORD REQD FLANGE THICKNESS ON OPERATION 427 *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8433672	
69	180	ROTATION LUG HOLE REPAIR (LEFT SET) MAX I.D. 2.210 RECORD BASE METAL DIMENSION *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8433672	
69	190	ROTATION LUG HOLE REPAIR (RIGHT SET) MAX I.D. 2.210 RECORD BASE METAL DIMENSION (CONTINUED)		001 MNPRA 002 02 003 MH05 005 X8433672	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 10 OF 10 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		OUTER CYLINDER							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		*C/P MOVE							
69	205	MANIFOLD LUG HOLE REPAIR (LEFT SIDE) MAX I.D. .500 *C/P MOVE					001 MNPRA 002 02 003 BE01		
69	210	MANIFOLD LUG HOLE REPAIR (RIGHT SIDE) MAX I.D. .500 *C/P MOVE					001 MNPRA 002 02 003 BE01		
		[REDACTED] TIME OUT _____ DATE OUT _____ *C/P MOVE				M	001 MNPRA 002 06 003 TE03		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****							
		[REDACTED] TIME OUT _____ DATE OUT _____ *C/P MOVE				M	001 MNPRA 002 06 003 TE03		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****							
		[REDACTED] TIME OUT _____ DATE OUT _____ *C/P MOVE				M	001 MNPRA 002 06 003 TE03		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****							
		[REDACTED] (IF MACHINED) TIME OUT _____ DATE OUT _____ (CONTINUED)				M	001 MNPRA 002 06 003 TE03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21001N			
		B		D					

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 11 OF 11 PAGES

2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN OUTER CYLINDER							
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		* C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****							
		[REDACTED]							
		TIME OUT _____ DATE OUT _____ *C/P MOVE				M	001 MNPNA 002 06 003 TE03		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****							
		[REDACTED]							
		TIME OUT _____ DATE OUT _____ *C/P MOVE				M	001 MNPNA 002 06 003 TE03		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****							
		[REDACTED]							
		TIME OUT _____ DATE OUT _____ *C/P MOVE				M	001 MNPNA 002 06 003 TE03		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****							
26B	250	BAKE 4 HRS AT 350 - 400F WITHIN 8 HRS OF ETCH					001 MNPNA 002 02 003 BK01		
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____							
(CONTINUED)									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21001N			
		B		D					

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 12 OF 12 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****				M		001 MNPNA 002 06 003 MLO4	
26	257	VAPOR DEGREASE *C/P MOVE						001 MNPRC 002 03 003 BG01	
26	260	SHOT PEEN GROUND SURFACE O.D. INTENSITY OF .006/.010A *C/P MOVE						001 MNPRC 002 01 003 SP02	
26	265	SHOT PEEN GROUND SURFACE LOWER BORE INTENSITY OF .006/.010A *C/P MOVE						001 MNPRC 002 01 003 SP02	
26	270	SHOT PEEN REWORKED SURFACE COLLAR I.D. INTENSITY .006/.010A *C/P MOVE						001 MNPRC 002 01 003 SP02	
26	275	SHOT PEEN GROUND SURFACE COLLAR FACE INTENSITY .006/.010A *C/P MOVE						001 MNPRC 002 01 003 SP02	
26	280	SHOT PEEN REWORKED SURFACE UPPER BORE & DOME AREA, I.D. INTENSITY .006 TO .010A *C/P MOVE						001 MNPRC 002 01 003 SP02	
26	285	SHOTPEEN ALL REWORKED AREAS INTENSITY .006/.010A *C/P MOVE						001 MNPRC 002 01 003 SP02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	

117

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 13 OF PAC 18

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
26	287	PREPARE CYLINDER O.D. FOR CHROME PLATE TYPE II CLASS III IAW MIL-STD-1501, MASK/FIXTURE/ETC <del>MECHANIC SIGN OFF REQUIRED</del> *C/P MOVE					001 MNPRC 002 02 003 BE01 005 X7432930		
26	288	PREPARE CYLINDER I.D. FOR CHROME PLATE. GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26	290	CHROME PLATE CYLINDER O.D MIL-STD-1501 TYPE II CLASS 3 SUFFICIENT TO GRIND BACK TO 12.496/12.499 (SEE PLATING DATA SHEET) *NOTE: APPLY MIN AMOUNT OF CHROME DATE OUT _____ TIME OUT _____ <del>MECHANIC SIGN OFF REQUIRED</del> *C/P MOVE					001 MNPRC 002 02 003 CP01 005 X7432930 008 CUC10		
263	300	BAKE 4 HRS AT 350 - 400F WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
86	305	FINISH GRIND CYLINDER O.D. 12.496/12.499 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE					001 MNPRC 002 03 003 GG02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21001N			
		B		D					

118

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 14 OF 14 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
26B	307	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	309	PREPARE CYLINDER UPPER/LOWER BORES I.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26	310	PREPARE CYLINDER UPPER/LOWER BORE ID FOR CHROME PLATE TYPE II CLASS III MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 BE01 005 X7132902		
26	312	CHROME PLATE CYLINDER LOWER BORE I.D. TYPE II CLASS III SUFFICIENT TO GRIND TO 11.874/11.878 (SEE PLATING DATA SHEET) *NOTE: APPLY MIN AMOUNT OF CHROME DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 CP01 005 X7132902 008 CI010		
26	320	CHROME PLATE CYLINDER UPPER BORE I.D. TYPE II CLASS III SUFFICIENT TO GRIND TO 11.746/11.756 (SEE PLATING DATA SHEET) *NOTE: APPLY MIN AMOUNT OF CHROME DATE OUT _____ TIME OUT _____					001 MNPRC 002 02 003 CP01 005 X7132902 008 CI020		

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 15 OF 15 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN OUTER CYLINDER					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		MECHANIC SIGN OFF REQUIRED----- *C/P MOVE							
26B	325	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE  DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
8	330	FINISH GRIND CYLINDER UPPER BORE ID 11.746/11.756 32 RMS MAINTAIN 0.005 TIR WITH DIA "A" RECORD TIR  LOW SPOTS IN CHROME DUE TO LOCAL REWORK ARE ACCEPTABLE IAW FIG 5-48 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED  RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRB 002 01 003 6101 004 X8745223		
8	335	FINISH GRIND CYLINDER LOWER BORE FINISH SIZE I.D. 11.874/11.878 32 RMS TO BE CONCENTRIC WITH DIA "A" WITHIN .005 TIR RECORD TIR  LOW SPOTS IN CHROME DUE TO LOCAL REWORK ARE ACCEPTABLE IAW FIG 5-48 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED  RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRB 002 01 003 6101 004 X8745223		
8G	340	HONE LOWER BORE TO REMOVE DEFECTS LOW SPOTS IN CHROME DUE TO LOCAL REWORK ARE ACCEPTABLE IAW FIG 5-48 (CONTINUED)					001 MNPRB 002 03 003 HV04 004 X8745197		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21001N			
		B		D					

120



## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 16 OF 16 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		*C/P MOVE							
86	345	HONE UPPER BORE TO REMOVE DEFECTS LOW SPOTS IN CHROME DUE TO LOCAL REWORK ARE ACCEPTABLE IAW FIG 5-48 *C/P MOVE					001 MNPRC 002 03 003 HV04 005 X8745107		
26	346	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 D001		
26	347	PREPARE AREA "C" I.D. FOR CHROME PLATE. GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BLO2		
26	348	PREPARE AREA "C" I.D. FOR CHROME PLATE TYPE II CLASS I MASK/FIXTURE/ETC <del>MECHANIC SIGN OFF REQUIRED</del>					001 MNPRC 002 02 003 BE01 005 X7751922		
26	350	CHROME PLATE AREA "C" I.D. TYPE II CLASS I SUFFICIENT TO GRIND TO 7.724/7.727 NOTE: APPLY MIN AMOUNT OF CHROME (SEE PLATING DATA SHEET)  DATE OUT _____ TIME OUT _____ <del>MECHANIC SIGN OFF REQUIRED</del> *C/P MOVE					001 MNPRC 002 02 003 CP01 005 X7751922 008 CI030		
26B	355	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21001N			
		B		D					

121

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 17 OF 17 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN OUTER CYLINDER					
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
8	360	FINISH GRIND AREA "C" I.D. FINISH SIZE ID 7.724/7.727 32 RMS MAINTAIN 0.003 TIR WITH UPPER BORE RECORD TIR RECORD WEAR 5th IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRB 002 01 003 GPO1 005 X0745100		
26B	365	BAKE 4 HRS AT 350-400F DATE IN TIME IN DATE OUT TIME OUT *C/P MOVE					001 MNPRC 002 02 003 BK01		
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****				M	001 MNPRNA 002 06 003 ML04		
26	372	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 0001		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****				M	001 MNPRNA 002 06 003 ZS01		
26	378	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE					001 MNPRC 002 01 003 BL02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21001N			
		B		D					

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 18 OF 18 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
26	380	CAD PLATE (SEE PLATING DATA SHEET) TIME OUT _____ DATE OUT _____ *C/P MOVE						001 MNPRC 002 03 003 CAD01	
26B	385	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD PLATE DATE IN _____ TIME IN _____  DATE OUT _____ TIME OUT _____ *C/P MOVE						001 MNPRC 002 02 003 BK01	
26	395	IRIDITE CHROMATE CONVERSION COATING *C/P MOVE						001 MNPRC 002 02 003 IR01	
		*C/P MOVE *C/P MOVE ACCOMPLISHED PRIOR TO USING IVD OPTION.				M		001 MNPNA 002 06 003 MLO4	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *							
26	398	IVD PLATE (INITIATED BY PLATING) **NOTE** OPERATION 385 MUST BE ACCOMPLISHED PRIOR TO USING IVD OPTION.						001 MNPRC 002 03 003 IVD01	
26	400	ALODINE IVD AREAS (INITIATED BY PLATING) *C/P MOVE						001 MNPRC 002 03 003 IAD01	
		MACHINE AREA "C" BUSHING P/N 4614598-101A *C/P MOVE						001 MNPRA 002 02 003 LE02	
69	410	AREA "C" I.D. BUSHING INSTALLATION P/N 4614598-101A INSTALL PER 451-93-3 AND APPLICABLE SUPPLEMENTS (CONTINUED)						001 MNPRA 002 02 003 BE01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21001N			
		B		D					

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 19 OF 19 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN						
			OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		.004-.008 FIT *C/P MOVE							
69	415	CUT OFF AREA "C" BUSHING & CHAMFER 30 DEG. X .090 *C/P MOVE					001 MNPRA 002 02 003 MH05 005 XB63672		
69	418	MACHINE UPPER END THRUST BEARING P/N 4G13612-101A *C/P MOVE					001 MNPRA 002 02 003 LE02		
69	419	UPPER END THRUST BEARING INSTALLATION P/N 4G13612-101A. INSTALL WITH MIL-S-141700 SEALING COMPOUND RECORD REQD WASHER THICKNESS REF OP 135 *C/P MOVE					001 MNPRA 002 02 003 BE01		
69	420	MACHINE UPPER END COLLAR BEARING *C/P MOVE P/N 4G13611-103A OR P/N 4G14597-101A					001 MNPRA 002 02 003 LE02		
69	421	UPPER END COLLAR BEARING INSTALLA- TION P/N 4G13611-103A OR P/N 4G13597-101A PRESS FIT .0024- .0044 INSTALL WITH SEALING COMPOUND GR AA PER MIL-S-22463D RECORD REQD FLANGE THICKNESS REF OP 130 *C/P MOVE					001 MNPRA 002 02 003 BE01		
69	422	MACHINE CROSSWIND LUG HOLE BUSHINGS (LEFT SIDE) *C/P MOVE P/N 4G13675-103A					001 MNPRA 002 02 003 LE02		
69	423	INSTALL CROSSWIND LUG HOLES (LEFT SIDE) P/N 4G13675-103A RECORD REQD FLANGE THICKNESS (CONTINUED)					001 MNPRA 002 02 003 BE01		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21001N	
		B	D		

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 20 OF 20 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		(UPPER) REF OP 170 NOTE: FOR FLANGE THICKNESS OF LOWER BUSHING, MAINTAIN DIMENSION OF OVERALL 2.185/2.188 .0009-.0024 FIT.							
69	424	MACHINE CROSSWIND LUG HOLE BUSHINGS (LEFT SIDE) FINISH SIZE 1.624/1.626 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X8422472		
69	426	MACHINE CROSSWIND LUG HOLE BUSHINGS (RIGHT SIDE) P/N 4613675-103A					001 MNPRA 002 02 003 LEO2		
69	427	INSTALL CROSSWIND LUG HOLES (RIGHT SIDE) BUSHING 4613675-103A RECORD REQD FLANGE THICKNESS (UPPER) REF OP 175 NOTE: FOR FLANGE THICKNESS OF LOWER BUSHING, MAINTAIN DIMENSION OF OVERALL 2.185/2.188 .0009-.0024 FIT.					001 MNPRA 002 02 003 BE01		
69	428	MACHINE CROSSWIND LUG HOLE BUSHINGS (RIGHT SIDE) FINISH SIZE 1.624/1.626 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS (CONTINUED)					001 MNPRA 002 02 003 MH05 005 X8422472		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				21001N			
		B							

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 21 OF 21 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO.		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		*C/P MOVE							
B	430	FINISH GRIND AREA "C" BUSHING I.D. 7.724/7.727 16RMS. MAINTAIN 0.003 TIR WITH UPPER BORE. RECORD TIR RECORD FINISH SIZE RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS						001 MNPRB 002 01 003 OP01 005 X0745100	
69	431	COLLAR O.D. BUSHING FINISH O.D. 9.440/9.445 OVERALL DIM 3.845/3.860 FOR FLANGED BUSHING 32 RMS TO IE CONCENTRIC WITH DIA "C" WITHIN .003 TIR RECORD TIR *C/P MOVE						001 MNPRA 002 02 003 MH05 005 X0550672	
69	432	UPPER END THRUST BEARING FINAL MACHINE. RECORD REQD WASHER THICKNESS REF OP 135 FINISH DISTANCE FROM TOP OF THRUST WASHER TO FACE OF AREA "C" 2.660/ 2.670 32 RMS. RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE						001 MNPRA 002 02 003 MH05 005 X0550672	
69	433	CHECK & RECORD THE FOLLOWING DIMENSIONS: *REQD* 1. COLLAR FACE TO TOP OF THRUST WASHER 2.660/2.670 RECORD ACTUAL 2. COLLAR FACE TO AREA "C" (CONTINUED)						001 MNPRA 002 02 003 MH05 005 2622672	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21001N			
		B		D					

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 22 OF 22 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO		

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PERPENDICULAR WITHIN .0005 INCH PER INCH (.004 MAX TIR). RECORD ACTUAL			
		3. TOP OF CROSSWIND BUSHINGS TO TOP OF THRUST WASHER 1.964/1.984 RECORD ACTUAL (LEFT) RECORD ACTUAL (RIGHT)			
		*C/P MOVE			
8	435	IF REWORKED CHECK CONCENTRICITY OF DIAMETER "C" TO DIAMETER "B". MAXIMUM 0.003 TIR. RECORD ACTUAL READING I.D. 7.724/7.727/7.729 WEAR *C/P MOVE		001 MNPRB 002 01 003 GI01 005 X8745221 006 X8745223	
8	440	IF O.D. OR UPPER BORE WAS REWORKED CHECK CONCENTRICITY OF UPPER BORE I.D. TO DIA "A" MAXIMUM .005 TIR RECORD ACTUAL READING *C/P MOVE		001 MNPRB 002 01 003 GI01 005 X8745221 006 X8745223	
8	445	IF O.D. OR LOWER BORE WAS REWORKED CHECK CONCENTRICITY OF LOWER BORE I.D. TO DIA "A" MAXIMUM OF .005 TIR RECORD ACTUAL READING *C/P MOVE		001 MNPRB 002 01 003 GI01 005 X8745221 006 X8745223	
69	469	MACHINE BALL, SCREW HOLE (LEFT SIDE) BUSHING P/N 4G13588-103A *C/P MOVE		001 MNPRB 002 02 003 LE02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 23 OF 23 PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	470	BALLSCREW HOLE (LEFT SIDE) BUSHING INSTALLATION P/N 4613588-103A IF FACE WAS WORKED BUSHING MUST HAVE FLANGE IAW 4S1-93-3. RECORD REQD FLANGE THICKNESS _____ REF OP 155 .0018/.0033 FIT.		001 MNPRA 002 02 003 BE01	
69	471	MACHINE BALLSCREW HOLE BUSHING (LEFT SIDE) FINISH SIZE 3.749/3.751 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8432672	
69	474	MACHINE BALLSCREW HOLE BUSHING (RIGHT SIDE) *C/P MOVE P/N 4613588-103A		001 MNPRA 002 02 003 LE02	
69	475	BALLSCREW HOLE (RIGHT SIDE) BUSHING INSTALLATION P/N 4613588-103A IF FACE WAS WORKED, BUSHING MUST HAVE FLANGE IAW 4S1-93-3. RECORD REQD FLANGE THICKNESS _____ REF OP 150 .0018-.0033 FIT RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	476	MACHINE BALLSCREW HOLE BUSHING RECORD REASON & CAUSE FOR EXCEEDING (RIGHT SIDE) FINISH SIZE 3.749/3.751 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED REWORK LIMITS _____ (CONTINUED)		001 MNPRA 002 02 003 MH05 005 X8432672	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	



## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 24 OF 24 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA			9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		*C/P MOVE							
69	478	MACHINE BALLSCREW CROSS PIN HOLE BUSHINGS (LEFT SIDE) *C/P MOVE P/N 4013591-103A P/N 4013672-103A						001 MNPRA 002 02 003 LE02	
69	480	INSTALL BALLSCREW CROSS PIN HOLES BUSHINGS (LEFT SIDE) P/N 4013591-103A P/N 4013672-103A FINISH SIZE 1.400/1.402 INSTALL IAW 451-93-3 125 RMS .0009-.0024 FIT RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE						001 MNPRA 002 02 003 BE01	
69	484	MACHINE BALLSCREW CROSS PIN HOLE BUSHINGS (RIGHT SIDE) *C/P MOVE P/N 4013591-103A P/N 4013672-103A						001 MNPRA 002 02 003 LE02	
69	485	INSTALL BALLSCREW CROSS PIN HOLES BUSHINGS (RIGHT SIDE) P/N 4013591-103A P/N 4013672-103A SIZE 1.400/1.402 125 RMS .0009-.0024 FIT RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE						001 MNPRA 002 02 003 BE01	
69	488	MACHINE ROTATION LUG HOLE BUSHINGS (LEFT UPPER) *C/P MOVE P/N 4013385-103A (CONTINUED)						001 MNPRA 002 02 003 LE02	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21001N			
		B		D					

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 25 OF 25 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN OUTER CYLINDER					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		P/N 4613382-103A							
69	500	INSTALL ROTATION LUG HOLES (LEFT UPPER) BUSHINGS P/N 4613385-103A P/N 4613382-103A .001-.0025 FIT					001 MNPRA 002 02 003 BE01		
69	502	MACHINE ROTATION LUG HOLE BUSHINGS (LEFT UPPER) FINISH SIZE 1.937/ 1.9385 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X8632672		
69	504	MACHINE ROTATION LUG HOLE BUSHINGS (LEFT LOWER) *C/P MOVE P/N 4613385-103A P/N 4613382-103A					001 MNPRA 002 02 003 LE02		
69	505	INSTALL ROTATION LUG HOLES (LEFT LOWER) BUSHINGS P/N 4613385-103A P/N 4613382-103A .001-.0025 FIT					001 MNPRA 002 02 003 BE01		
69	507	MACHINE ROTATION LUG HOLE BUSHING (LEFT LOWER) FINISH SIZE 1.937/ 1.9385 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 02 003 MH04 005 X8632672		
69	509	MACHINE ROTATION LUG HOLE BUSHINGS (RIGHT UPPER) *C/P MOVE P/N 4613385-103A P/N 4613382-103A					001 MNPRA 002 02 003 LE02		
69	510	INSTALL ROTATION LUG HOLES (RIGHT UPPER) BUSHINGS P/N 4613385-103A P/N 4613382-103A (CONTINUED)					001 MNPRA 002 02 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTION/L CODE	A		C		21001N			
		B		D					

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 26 OF 26 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN OUTER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		.001-.0025 FIT							
69	512	MACHINE ROTATION LUG HOLE BUSHING (RIGHT UPPER) FINISH SIZE 1.937/ 1.9385 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X8152672		
69	514	MACHINE ROTATION LUG HOLE BUSHINGS (RIGHT LOWER) *C/P MOVE P/N 4G13385-103A P/N 4G13382-103A					001 MNPRA 002 02 003 LE02		
69	515	INSTALL ROTATION LUG HOLES (RIGHT SIDE) BUSHINGS P/N 4G13385-103A P/N 4G13382-103A .001-.0025 FIT					001 MNPRA 002 02 003 BE01		
69	516	MACHINE ROTATION LUG HOLE BUSHINGS (RIGHT LOWER) FINISH SIZE 1.937/ 1.9385 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X8152672		
69	519	MACHINE MANIFOLD LUG HOLE BUSHINGS (LEFT SIDE) *C/P MOVE P/N 4G13673-103A					001 MNPRA 002 02 003 LE02		
69	520	MANIFOLD LUG HOLES (LEFT SIDE) BUSHINGS P/N 4G13673-103A FINISH I.D. .323/.326 125 RMS .0004-.0019 FIT RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS (CONTINUED)					001 MNPRA 002 02 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				21001N			
		B				D			

## 21001N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 27 OF 27 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN OUTER CYLINDER	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		REWORK LIMITS _____ *C/P MOVE			
69	524	MACHINE MANIFOLD LUG HOLE BUSHINGS (RIGHT SIDE) *C/P MOVE P/N 4613673-103A		001 MNPRA 002 02 003 LE02	
69	525	MANIFOLD LUG HOLES (RIGHT SIDE) BUSHINGS P/N 4613673-103A FINISH T.D. .323/.326 125 RMS .0003-.0019 FIT		001 MNPRA 002 02 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE			
	540	DEGREASE & SEAL BUSHING FLANGES *C/P MOVE		001 MNPDP 002 01 003 BE01	
	545	PAINT & DECAL AS REQUIRED IAW 4S-1-182 AND 4S1-93-3 *C/P MOVE		001 MNPDP 002 09 003 WE03	
	550	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD*		001 MNPDP 002 01 003 MU06	
	555	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*		001 MNPDP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21001N
		B	D	

## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89107

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNP GP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES CSA MAIN	11. STOCK NUMBER	12. OPTIONAL AF DWG 7926446 4S-1-182 4S1-93-3 AND SUPPLEMENTS
13. SERIAL NUMBER	14. NOUN INNER CYLINDER	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4G1141	4-107A	NSN C/N 1620004176249 74626A 17576A 17577A 17578A 17575A 17687A			
		GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3 FMPI IAW MIL-STD-1949 P/O N01561			
		BAKE IAW 4S-1-182 MAOI 74-12 GRIND IAW MIL-STD-866 TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13145 CHROME PLATE IAW MIL-STD-1501 P/O N61891 & P/O N41321 GRIT BLAST IAW MIL-STD-1504			
		CAD PLATE IAW MIL-STD-870 TYPE II CLASS II BRUSH NICKLE PLATE IAW MIL-STD-845 EPI IAW MIL-STD-4846			
		STRIP CHROME IAW MIL-STD-871 IVD PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541 *****200 M 280,000-300,000 KSI*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFIC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89107

PAGE 2 OF 2 PAGES

2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13. SERIAL NUMBER			14 NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		* COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS							
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP							
	001	4G11414-107A 7926445 7926446							
34C5	005 *REQD*	DISASSEMBLE/REMOVE BUSHINGS *C/P MOVE					001 MNPBP 002 01 003 SD03		
34C	007 *REQD*	CHEM CLEAN *C/P MOVE					001 MNPBW 002 03 003 SL01		
34B	009 *REQD*	BLAST CLEAN ONLY *C/P MOVE					001 MNPBW 002 03 003 BL01		
34B	011 *REQD*	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____					001 MNPBW 002 03 003 BK03		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21002N			
		B		D					

## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89107

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL					
13. SERIAL NUMBER		14. NOUN INNER CYLINDER							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		[REDACTED] *C/P MOVE				M	001 MNPBW		
	*REQD						002 05		
							003 ML01		
34E	030	E AND I CYLINDER O.D. 10.994-10.997							
	*REQD	WEAR 10.992							
		CYLINDER I.D. (STD) 10.176-10.181							
		WEAR 10.186							
		(1ST O/S) 10.190-10.195							
		WEAR 10.200							
		(2ND O/S) 10.205-10.210							
		WEAR 10.215							
		LARGE ATTACH BUSHING I.D. 10.008-10.014 WEAR 10.018							
		RECORD BASE METAL DIM.							
		SMALL ATTACH BUSHING I.D. 6.008-6.014 WEAR 6.018							
		RECORD BASE METAL DIM.							
		SMALL LUG OVERALL THICKNESS 1.75 MIN							
		POSITIONER LUG I.D. .6245-.6280							
		WEAR .640							
		RETAINER GROOVE I.D. 10.575-10.583							
		WEAR 10.585							
		METERING PIN BUSHING 4.494-4.496							
		WEAR 4.500							
		BASE METAL 4.674-4.724							
		RECORD BASE METAL DIM.							
		I.D. SPLINES 10.285-10.290							
		MAX. 10.295							
		*****NOTE*****							
		CYLINDERS WITH MORE THAN .003							
		OF CHROME ON THE I.D. DIAMETER							
		(.0015 PER SIDE) WILL REQUIRE							
		STRIP.							
		NOTE: A MINIMUM OF TWO FMPI							
		(CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
						21002N			
		B				D			

## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89107

PAGE 4 OF 4 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		OPERATIONS REQUIRED ON THIS PART. *C/P MOVE							
04E	040	HAND POLISH CYL ID TO REMOVE DEFECTS STD. 10.176-10.181-10.186 1ST O/S 10.190-10.195-10.200 2ND O/S 10.205-10.210-10.215						001 MNPGW 002 04 003 EI01	
		16RMS 25.500 FROM TOP OF CYL 4-12RMS 25.500/38.000 FROM TOP OF CYLINDER IF NO REWORK IS REQUIRED RECORD DIMENSION							
		*C/P MOVE							
26	044	VAPOR DEGREASE *C/P MOVE						001 MNPRC 002 03 003 DG01	
26	046	STRIP CAD *C/P MOVE						001 MNPRC 002 03 003 CS01	
26	048	STRIP RUST *C/P MOVE						001 MNPRC 002 03 003 CS02	
69	050	LARGE ATTACH LUG HOLE REPAIR MAXIMUM SIZE 10.470 RECORD BASE METAL DIMENSION						001 MNPRA 002 03 003 MH05	
69	060	SMALL ATTACH LUG HOLE REPAIR MAXIMUM SIZE 6.480 RECORD BASE METAL DIMENSION						001 MNPRA 002 03 003 MH05	
69	070	MACHINE SMALL ATTACH FACE TO REMOVE CORROSION 1.75 MIN LUG THICKNESS *C/P MOVE						001 MNPRA 002 03 003 MH05	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21002N			
		B		D					



## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89107

PAGE 5 OF 5 PAGES

2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN INNER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
29	080	POSITIONER LUG REPAIR MAXIMUM SIZE .750 *C/P MOVE					001 MNPRA 002 02 003 BE01		
69	090	SECOND REPAIR METERING PIN HOLE MACHINE FOR BUSHING IAW T.O 4S1-93-3 4.674 MIN. 4.724 MAX. CONCENTRIC TO DIA A WITHIN .003 TIR RECORD TIR					001 MNPRA 002 02 003 MH05		
		RECORD BASE METAL DIMENSION *C/P MOVE							
26	095	VAPOR DEGREASE *C/P MOVE					001 MNPRA 002 03 003 IG01		
26	100	STRIP CHROME FROM CYLINDER O.D. REVERSE CURRENT METHOD ONLY *C/P MOVE					001 MNPRA 002 02 003 SC02		
26	110	STRIP CHROME FROM CYLINDER I.D. REVERSE CURRENT METHOD ONLY & RETURN TO E & I (STATION 34E) FOR CONDITION CHECK OF I.D. *C/P MOVE					001 MNPRA 002 02 003 SC02		
34E	120	CONDITION CHECK & MIC CYL I.D. STD. 10.176-10.181-10.186 1ST O/S 10.190-10.195-10.200 2ND O/S 10.205-10.210-10.215					001 MNPRA 002 04 003 EI01		
		RECORD DIMENSION *C/P MOVE							
86	130	FIRST GRIND CYLINDER OD FOR CHROME MIN OD 10.982 TO BE CONCENTRIC TO DIA. A WITHIN .003 TIR RECORD TIR RECORD BASE METAL DIMENSION					001 MNPRA 002 03 003 GE02 005 X6745007		
		*C/P MOVE							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21002N
		B	D	

## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89107

PAGE 6 OF 6 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
BG	140	FIRST GRIND CYLINDER OD UPPER BRG SURFACE MIN DIA 10.975 TO BE CONCENTRIC TO I.D. WITHIN .003 TIR RECORD TIR					001 MNPBR 002 03 003 G602 005 X8745207		
		RECORD BASE METAL DIMENSION *C/P MOVE							
BG	150	HONE I.D. AS REQUIRED TO CLEAN-UP 10.176-10.181-10.184 STANDARD 10.188-10.198 1ST OVERSIZE 10.203-10.213 2ND OVERSIZE					001 MNPBR 002 03 003 H404 005 X8745197		
		32 RMS 25.0-38.0 FROM OPEN END 32 RMS ABOVE SEAL AREA RECORD FINAL DIMENSION ***NOTE: SEAL AREA MUST BE DEFECT							
		FREE-LOCAL REWORK ABOVE & BELOW SEAL AREA *C/P MOVE							
B	160	GRIND I.D. AS REQUIRED TO CLEAN-UP 10.176-10.181-10.184 STANDARD 10.188-10.198 1ST OVERSIZE 10.203-10.213 2ND OVERSIZE					001 MNPBR 002 01 003 G101 005 X8745225		
		32 RMS 25.0-38.0 FROM OPEN END 32 RMS ABOVE SEAL AREA RECORD FINAL DIMENSION ***NOTE: SEAL AREA MUST BE DEFECT					006 X8745227		
		FREE-LOCAL REWORK ABOVE & BELOW SEAL AREA *C/P MOVE							
		REWORKED AREAS AS NECESSARY. DATE OUT _____ TIME OUT _____ *C/P MOVE				M	001 MNPNA 002 04 003 TE03		
				***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. (CONTINUE)					
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				21002N			
		B				D			

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		* * * * *							
26B	180	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____					001 MNP RC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
86	190	POLISH I.D. TO REMOVE BURN INDICATION RECORD BASE METAL DIMENSION _____ *C/P MOVE					001 MNP RB 002 03 003 BE01		
		[REDACTED] CH I.D. AFTER HONE DATE OUT _____ TIME OUT _____ *C/P MOVE * * * * * N O T E * * * * *				M	001 MNP NA 002 04 003 TE03		
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * * * * *							
26B	210	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____					001 MNP RC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		[REDACTED] *C/P MOVE * * * * * N O T E * * * * *				M	001 MNP NA 002 04 003 ML04		
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. * * * * *							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21002N			
		B		D					

## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89107

PAGE 8 OF 8 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26	225	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
26	230	SHOT PEEN GROUND SURFACE CYL O.D. .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	240	SHOT PEEN GROUND SURFACE CYL UPPER END O.D. .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	250	SHOT PEEN CYL I.D. .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	260	SHOT PEEN REWORKED SURFACE METERING PIN BORE .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	270	SHOT PEEN ALL OTHER REWORKED AREAS .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	280	PREPARE CYLINDER O.D./UPPER O.D. FOR CHROME PLATE TYPE II CLASS III MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED----- *C/P MOVE					001 MNPRC 002 03 003 BE01 005 XF412360		
26	290	BLAST CYL OD USING 80 - 180 GRIT ALUM OXIDE OR GARNET *C/P MOVE					001 MNPRC 002 01 003 BL02		
26	300	BLAST-CYL UPPER O.D. USING 80-180 GRIT ALUM OXIDE OR GARNET *C/P MOVE					001 MNPRC 002 01 003 BL02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21002N			
		B		D					

## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89107

PAGE 9 OF 9 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL					
13. SERIAL NUMBER		14. NOUN INNER CYLINDER							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26	310	VAPOR DEGREASE/HAND CLEAN O.D. AREAS FOR CHROME PLATE *C/P MOVE					001 MNPRC 002 02 003 BE01		
26	320	CHROME PLATE CYLINDER O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 10.994/10.997					001 MNPRC 002 02 003 CR01 005 X8412360		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED-----> *C/P MOVE					008 C0010		
26	330	CHROME PLATE UPPER END O.D. TYPE II CLASS III SUFFICIENT TO GRIND BACK TO 10.998/10.990					001 MNPRC 002 02 003 CR01 005 X8412360		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED-----> *C/P MOVE					008 C0020		
26B	340	BAKE 4 HRS AT 350-400F. WITHIN 4HRS OF CHROME DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	345	RE-SHOTPEEN CYLINDER I.D. IF REQUIRED .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SF02		
86	350	HONE CYLINDER I.D. AFTER SHOTPEEN STANDARD 10.176-10.181-10.186 1ST D/S 10.190-10.195-10.200 2ND D/S 10.205-10.210-10.215					001 MNPRB 002 03 003 HV04 005 X8745187		
		10 RMS 25.5-38.0 FROM OPEN END 16 RMS ABOVE SEAL AREA IF MORE THAN .0024 MATERIAL WAS (CONTINUED)							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21002N	
		B	D		

## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89107

PAGE 10 OF 10 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		REMOVED FROM THE I.D. (SEE OPERATION 120 OR 160 FOR READING) OR I.D. DOES NOT CLEAN-UP, CYLINDER MUST BE RE-SHOTPEENED & RE-HONED ON AN OVERLAY							
		RECORD RMS IN SEAL AREA _____ RECORD RMS ABOVE SEAL AREA _____ RECORD FINAL DIMENSION _____ *C/P MOVE							
26	355	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 IG02		
26	358	PREPARE I.D. FOR CHROME PLATE IAW P/O N41321, MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED----->					001 MNPRC 002 03 003 BE01 005 X2831900		
26	360	CHROME PLATE I.D. .0004/.0007 RECORD MEASURED THICKNESS _____ DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED-----> *C/P MOVE					001 MNPRC 002 03 003 CR01 005 X2831900 008 CI010		
26B	370	BAKE 4 HRS AT 350 TO 400 F WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 03 003 BK01		
8G	380	REIDENTIFY IAW DWG 7926446 STAMP -30 (1ST O/S) -50 (2ND O/S) RECORD ACTUAL DIMENSIONS _____ *C/P MOVE					001 MNPRB 002 03 003 BE01		
8G	390	FINISH GRIND CYLINDER O.D. 10.994/ 10.997 16RMS TO BE CONCENTRIC TO I.D. WITHIN (CONTINUED)					001 MNPRB 002 03 003 GG02 005 X8745207		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21002N			
		B		D					

## 210021 WORK CONTROL DOCUMENT (MEDS)

1 DATE

89107

PAGE 1 OF 1 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN INNER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		.003 TIR RECORD TIR RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE							
86	400	FINISH GRIND UPPER END O.D. FINISH DIA 10.988/10.990 16RMS TO BE CONCENTRIC TO I.D. WITHIN .003 TIR RECORD TIR *C/P MOVE					001 NAME 002 OS 003 BEOL 005 Y97		
86	410	VISUAL INSPECT CYL I.D. AFTER CHROME FOR DEFECTS & RMS. 12 RMS IN SEAL AREA 24 RMS ABOVE SEAL AREA. RECORD RMS IN SEAL AREA RECORD RMS ABOVE SEAL AREA IF DEFECTIVE INITIATE OPERATION 420 *C/P MOVE					001 NAME 002 OS 003 BEOL		
86	420	HONE CYLINDER I.D. STANDARD 10.176-10.181-10.186 1ST O/S 10.190-10.195-10.200 2ND O/S 10.205-10.210-10.215 12 RMS 25.5-38.0 FROM OPEN END 24 RMS ABOVE SEAL AREA RECORD RMS IN SEAL AREA RECORD RMS ABOVE SEAL AREA RECORD FINAL DIMENSION *C/P MOVE					001 NAME 002 OS 003 HUNE 005 Y97		
268	430	BAKE 4 HRS AT 350 TO 400F DATE IN _____ TIME IN: _____ DATE OUT _____ TIME OUT: _____ (CONTINUED)					001 NAME 002 OS 003 BAK		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		210021			
		B		D					

## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89107

PAGE 1 OF 1 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN INNER CYLINDER						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		*C/P MOVE							
		*C/P MOVE ***** NOTE ***** IF LAST NOT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****				M	001 MRPMT 002 06 003 ML04		
26	445	VAPOR DEGREASE *C/P MOVE					001 MRPMT 002 06 003 1501		
		*C/P MOVE ***** NOTE ***** IF LAST NOT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****				M	001 MRPMT 002 06 003 2501		
26	455	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE					001 MRPMT 002 06 003 1501		
26	460	CAD PLATE O.D. TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MRPMT 002 06 003 CA01		
26	470	BAKE 24 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____					001 MRPMT 002 06 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21002N			
		B		D					



## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89107

PAGE 13 OF 13 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		INNER CYLINDER							
15 DISPATCH STATION		16 PERP RCC/OP NO.		17 WORK TO BE ACCOMPLISHED		18 MECHANIC		19 "P" "Q"	
26		490		IRIDITE-CHROMATE CONVERSION COATING *C/P MOVE				001 MNPRC 002 03 003 IR01	
				[REDACTED] COMPLISH PRIOR TO IVD OPTION *C/P MOVE		M		001 MNPNA 002 04 003 ML04	
				***** NOTE ***** IF LAST NDT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****					
26		501		IVD PLATE (INITIATED BY PLATING) **NOTE** IF CHROME REWORK WAS DONE OPERATION 470 MUST BE ACCOMPLISHED PRIOR TO IVD OPTION *C/P MOVE				001 MNPRC 002 03 003 IV01	
26		502		ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE				001 MNPRC 002 03 003 TA01	
69		509		MACHINE METERING PIN HOLE BUSHING *C/P MOVE P/N 7926422-01				001 MNPRA 002 03 003 LB03	
69		510		METERING PIN HOLE INSTALL BUSHING P/N 7926422-01 & PACKING P/N ARP568-047 IAW T.O. AS1-93-3 ALLOW SUFFICIENT MATERIAL ON ID TO GRIND TO 4.494/4.496. .004-.006 SHRINK FIT RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE				001 MNPRA 002 03 003 BE01	
8		520		FINISH GRIND METERING PIN BUSHING ID 4.494/4.496 32 RMS TO BE CONCENTRIC TO DIA A WITHIN (CONTINUED)				001 MNPRE 002 01 003 GR01 005 X8745180	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT					
DISPATCH		FUNCTIONAL CODE		A		C		21002N	
				B		D			

## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89107

PAGE 14 OF 14 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN INNER CYLINDER						
18. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		.003 TIR RECORD TIR RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING							
		REWORK LIMITS RECORD CRITICAL DIMENSION *C/P MOVE							
26BP	530	BRUSH PLATE ID OF METERING PIN HOLE BUSHING USING NICKEL TUNGSTEN OR NICKEL COBALT *C/P MOVE					001 MNPRC 002 02 003 BR01		
34C5	535	PRESSURE CHECK INNER CYL IAW TEST PROCEDURES IN T.O. 451-93-3 RECORD LEAKAGE 1ST HOUR RECORD LEAKAGE 4TH HOUR					001 MNPRG 002 01 003 PA07 004 PA0001		
69	538	MACHINE LARGE ATTACH BEARING *C/P MOVE P/N 4G13490-109A					001 MNPRA 002 02 003 LE03		
69	540	LARGE ATTACH BEARING INSTALLATION P/N 4G13490-109A .004-.006 FIT RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 02 003 BR01		
69	542	MACHINE LARGE ATTACH BEARING FINISH SIZE 10.008/10.014 *C/P MOVE					001 MNPRA 002 02 003 MH05		
69	548	MACHINE SMALL ATTACH BEARING *C/P MOVE P/N 4G13491-103A					001 MNPRA 002 02 003 LE03		
69	550	SMALL ATTACH BEARING INSTALLATION P/N 4G13491-103A FINISH SIZE 6.008/6.014 .001-.003 FIT (CONTINUED)					001 MNPRA 002 02 003 BR01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21002N			
		B		D					

146

## 21002N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89107

PAGE 15 OF 15 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED			
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL					
13. SERIAL NUMBER			14. NOUN								
			INNER CYLINDER								
15. DISPATCH STATION		16. PERF RCC/OP NO.		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"		
69		551		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE							
69		559		MACHINE SMALL ATTACH BEARING FINISH SIZE 6.008/6.014 *C/P MOVE					001 MNPRA 002 02 003 MH05		
69		559		MACHINE POSITIONER LUG BUSHING *C/P MOVE P/N 4G14604-101A					001 MNPRA 002 02 003 LB02		
69		560		POSITIONER LUG BUSHING INSTALLATION INSTALL IAW 4S1-93-3. FINISH SIZE .6245/.628 P/N4G14604-101A .0005-.001 PRESS FIT					001 MNPRA 002 02 003 BE01		
				RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE							
34A		570		DEGREASE *C/P MOVE					001 MNP GP 002 06 003 ML01		
34P		600		PAINT IAW 4S-1-182 & 4S1-93-3 DECAL AS REQUIRED *C/P MOVE					001 MNP GP 002 09 003 WE03		
34 C5		610		FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD*					001 MNP GP 002 01 003 ML06		
34 C5		620		FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*					001 MNP GP 002 01 003 ML06		
21. FINAL DESTINATION				22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH		FUNCTIONAL CODE		A		C		21002N			
				B		D					

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**PAGE\_\_OF\_\_PAGES**

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**PAGE\_\_OF\_\_PAGES**

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**DATE**

**PAGE\_\_OF\_\_PAGES**

21.	FINAL DESTINATION	22.	COORDINATION/INITIATING RCC SIGNATURE/DATE	23.	DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	LAKE PRODUCTION CO 10-10-68		
		B		D	ADORN 150

**PAGE\_\_OF\_\_PAGES**

151

# WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO 111111	3. QUANTITY 1	4. PRODUCTION SEC/RCC 1	5. DATE SCHED 95 11 1	6. DATE COMPLETED 95 11 1
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7. PART NUMBER 111111	8. TECH DATA 111111	9. ITEM SERIAL NO. 111111
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10. MODEL-DESIGN-SERIES 111111	11. STOCK NUMBER 111111	12. OPTIONAL 111111
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13. SERIAL NUMBER 111111	14. NOUN 111111
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15. DISPATCH STATION 111111	16. PERF RCC/OP NO 111111	17. WORK TO BE ACCOMPLISHED 111111	18. MECHANIC 111111	19. "P" 111111	20. "Q" 111111
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		17. WORK TO BE ACCOMPLISHED 111111	18. MECHANIC 111111	19. "P" 111111	20. "Q" 111111
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		17. WORK TO BE ACCOMPLISHED 111111	18. MECHANIC 111111	19. "P" 111111	20. "Q" 111111
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		17. WORK TO BE ACCOMPLISHED 111111	18. MECHANIC 111111	19. "P" 111111	20. "Q" 111111
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		17. WORK TO BE ACCOMPLISHED 111111	18. MECHANIC 111111	19. "P" 111111	20. "Q" 111111
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		17. WORK TO BE ACCOMPLISHED 111111	18. MECHANIC 111111	19. "P" 111111	20. "Q" 111111
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		17. WORK TO BE ACCOMPLISHED 111111	18. MECHANIC 111111	19. "P" 111111	20. "Q" 111111
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		17. WORK TO BE ACCOMPLISHED 111111	18. MECHANIC 111111	19. "P" 111111	20. "Q" 111111
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		17. WORK TO BE ACCOMPLISHED 111111	18. MECHANIC 111111	19. "P" 111111	20. "Q" 111111
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		17. WORK TO BE ACCOMPLISHED 111111	18. MECHANIC 111111	19. "P" 111111	20. "Q" 111111
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		17. WORK TO BE ACCOMPLISHED 111111	18. MECHANIC 111111	19. "P" 111111	20. "Q" 111111
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21. FINAL DESTINATION DISPATCH 111111	21. FUNCTIONAL CODE 111111	22. COORDINATION/INITIATING RCC SIGNATURE/DATE A 111111	22. COORDINATION/INITIATING RCC SIGNATURE/DATE C 111111	23. DOCUMENT/SN 111111
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21. FINAL DESTINATION DISPATCH 111111	21. FUNCTIONAL CODE 111111	22. COORDINATION/INITIATING RCC SIGNATURE/DATE B 111111	22. COORDINATION/INITIATING RCC SIGNATURE/DATE D 111111	23. DOCUMENT/SN 111111
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154

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
				MNP GP					
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO	
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL					
CSA MAIN				4S-1-182 AND SUPPLEMENTS 451-93-3					
13. SERIAL NUMBER		14. NOUN							
		LOWER DRAG SHAFT							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
P/N 461353	9-101A	NSN C/N 1620001164435 17575A 17576A 17577A 17578A							
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FMPI IAW MIL-STD-1949 P/O N01561							
		STRIP CHROME IAW MIL-STD-871 GRIND IAW MIL-STD-866 TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-C-12165							
		CHROME PLATE IAW MIL-STD-1501 TYPE II CLASS III P/O N61891 CAD PLATE IAW MIL-STD-870 FPI IAW MIL-STD-4846							
		BAKE IAW 4S-1-182 MAOI 74-12 IVD PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541							
		***300 M 280,000-300,000 KSI*** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLI- CABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.							
		COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						21006N			
						155			

## 21006N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 2 OF 2 PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN LOWER DRAG SHAFT	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STATIONS.  WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4613539-101A			
	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNP GP 002 01 003 SD03	
	*REQD*	CHEM CLEAN *C/P MOVE		001 MNP GW 002 03 003 SL01	
	*REQD*	BLAST CLEAN *C/P MOVE		001 MNP GW 002 03 003 BL01	
	*REQD*	BAKE 4 HRS AT 350-400F		001 MNP GW 002 03 003 BK03	
		DATE IN _____ TIME IN _____			
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
	*REQD*	*C/P MOVE	M	001 MNP NA 002 05 003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21006N
		B	D	

## 21006N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 3 OF 3 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		LOWER DRAG SHAFT							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		E AND I INSPECTION					001 MNPRG		
		SHAFT OD 4.4965/4.4975 WEAR 4.4955					002 04		
		NOTE: A MINIMUM OF TWO EXPI'S					003 EIO1		
		ARE REQUIRED ON THIS PART.							
		*C/P MOVE							
26	035	VAPOR DEGREASE *C/P MOVE					001 MNPRC		
							002 03		
							003 DGO1		
26	040	STRIP CAD *C/P MOVE					001 MNPRC		
							002 02		
							003 CS01		
26	045	STRIP RUST *C/P MOVE					001 MNPRC		
							002 02		
							003 CS02		
26	050	STRIP CHROME FROM SHAFT *C/P MOVE					001 MNPRC		
							002 02		
							003 SC02		
8	060	FIRST GRIND SHAFT FOR CHROME MINIMUM GRIND SIZE O.D. 4.4815 *C/P MOVE					001 MNPRC		
							002 02		
							003 GE01		
		TIME OUT _____ DATE OUT _____					001 MNPRC		
		*C/P MOVE					002 06		
							003 TE03		
		***** NOTE *****							
		IF LAST NDI OPERATION IS COMPLETED*							
		HERE, TAKE PRODUCTION COUNT *							
		*****							
26B	080	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH					001 MNPRC		
							002 02		
							003 BK01		
(CONTINUED)									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21006N			
		B		D					

## 21006N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 4 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN LOWER DRAG SHAFT						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE							
		<p>***** NOTE *****</p> <p>IF LAST NO1 OPERATION IS COMPLETED*</p> <p>HERE, TAKE PRODUCTION COUNT *</p> <p>*****</p>				M	001 MNPN A		
							002 06		
							003 MLD4		
26	095	VAPOR DECREASE *C/P MOVE					001 MNPRC		
							002 03		
							003 DB01		
26	100	SHOTPEEN SHAFT FOR CHROME INTENSITY OF .008/.012 A2 *C/P MOVE					001 MNPRC		
							002 01		
							003 SP02		
26	103	PREPARE SHAFT FOR CHROME PLATE MASK/FIXTURE/ETC *C/P MOVE					001 MNPRC		
		MECHANIC SIGN OFF REQUIRED					002 02		
							003 BE01		
26	107	PREPARE SHAFT FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC		
							002 01		
							003 BL02		
26	110	CHROME PLATE SHAFT SUFFICIENT TO GRIND BACK TO 4.4965/4.4975 DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC		
							002 02		
							003 CP01		
							004 CD010		
26B	120	BAKE 4 HRS AT 350F TO 400F WITHIN 4 HRS OF CHROME					001 MNPRC		
							002 02		
							003 BK01		

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21006N
		B	D	

## 21006N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 5 OF 5 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		LOWER DRAG SHAFT							
15 DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20 "Q"	
		DATE IN: _____ TIME IN: _____							
		DATE OUT: _____ TIME OUT: _____							
		*C/P MOVE							
8	130	FINISH GRIND SHAFT FINISH DIAMETER O.D. 4.4965/4.4975 63 RMS					001 MNPRB 002 02 003 GE01		
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
		*C/P MOVE							
26B	140	BAKE 4 HRS AT 350F TO 400F					001 MNPRC 002 02 003 BAO1		
		DATE IN: _____ TIME IN: _____							
		DATE OUT: _____ TIME OUT: _____							
		*C/P MOVE							
		*C/P MOVE					001 MNPNB 002 06 003 MLC4		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *				M			
		*****							
26	155	VAPOR DEGREASE				*C/P MOVE	001 MNPRC 002 03 003 DG01		
		*C/P MOVE					001 MNPNB 002 06 003 ZS01		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *				M			
		*****							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21006N			
		B		D					

## 21006N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 6 OF 6 PAGES

2 J 3 ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN LOWER DRAG SHAFT						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
26	165	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED. *C/P MOVE					001 MNPRC 002 01 003 BLO2		
26	170	CAD PLATE TYPE II CLASS II TIME OUT: _____ DATE OUT: _____ *C/P MOVE					001 MNPRC 002 03 003 CAD1		
263	180	BAKE 24 HRS AT 350F TO 400F WITHIN 4 HRS OF CAD. DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
26	185	CHROMATE CONVERSION COATING (IRIDITE) *C/P MOVE					001 MNPRC 002 02 003 IR01		
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****				M	001 MNPNA 002 06 003 MLO4		
26	191	IVD PLATE (INITIATED BY PLATING) NOTE**OPERATION 180 MUST BE ACCOMPLISHED PRIOR TO IVD OPTION IF CHROME PLATE WAS DONE *C/P MOVE					001 MNPRC 002 03 003 IVD1		
26	192	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE					001 MNPRC 002 03 003 TA01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21006N			
		B		D					



## 21006N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 7 OF 7 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN LOWER DRAG SHAFT						
15 DISPATCH STATION	16 PERF R C N	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
	193	DEGREASE & PREPAINT *C/P MOVE					001 MNP GP 002 09 003 PP01		
	200	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958					001 MNP GP 002 01 003 MU06		
	210	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*					001 MNP GP 002 01 003 MU06		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21006N			
		B		D					

## 21007N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 1 OF 1 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNPGP		

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
	45-1-182	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL SUPPLEMENTS
CSA MAIN		74644A 17575A

13 SERIAL NUMBER	14 NOUN
	SPLINED TUBE

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
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P/N 4613413-101A		NSN N.S.L.	C/N 74644A 17575A <del>17576A</del> 17577A 17578A		
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***** UNIT COST: \$10,815.00*****					
GOVERNING DIRECTIVES: AFLCR 66-51					
MANOI 66-3					

FMPI		IAW MIL-I-5858		
		P/O N01561		
GRIND		IAW MIL-STD-863		
SHOT PEEN		IAW MIL-S-12165		
CAD PLATE		IAW MIL-STD-870		
NICKEL PLATE		IAW MIL-STD-863		
		P/O N62541		
PHOSPHATE TREATMENT		IAW DOD-P-14222		
		P/O N73061		
DRY FILM LUBE		IAW MIL-L-46010		
TEMPER ETCH		IAW MIL-STD-867		
BAKE		IAW 45-1-182		
		IAW MAOI-74-12		
BLAST		IAW MIL-STD-1504		

\*\*\*\*\*MATERIAL: 3004 (289/309 KSI)\*\*\*\*\*

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
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(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	21007N	
		B	D		

162

## 21007N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SPLINED TUBE						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		* COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	4612432-101A							
	005	DISASSEMBLE *C/P MOVE					001 MNPGP		
	*REQD*						002 01		
							003 SD03		
		DEGREASE ONLY *C/P MOVE					001 MNPGW		
	*REQD*						002 02		
							003 DD02		
		BLAST CLEAN ONLY *C/P MOVE					001 MNPGW		
	*REQD*						002 03		
							003 BL01		
		BAKE 4 HRS AT 350-400F					001 MNPGW		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
							003 BK03		
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21007N			
		B		D					

163

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN SPLINED TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		[REDACTED] *C/P MOVE				M	001 MNPNA 002 05 003 MLO4		
8	025	CHECK SEAL GROOVE O.D. BEARING AREA O.D. FOR CONCENTRICITY. TO BE WITHIN .004 TIR RECORD READING _____ *C/P MOVE					001 MNPRA 002 03 003 GE05		
	*REQD*								
8	026	CHECK BEARING AREA O.D. TO SPLINES ACROSS .3840 PINS FOR CONCENTRICITY IAW DRWG 4613413 TO BE WITHIN .006 TIR. RECORD READING _____ *C/P MOVE					001 MNPRA 002 03 003 GE05		
	*REQD*								
		E & I INSPECTION NOTE: IF CONCENTRICITY CHECK (025) EXCEEDS .004 TIR - ROUTE FOR REPAIR.					001 MNPBW 002 04 003 EIO1		
		NOTE: IF CONCENTRICITY CHECK (026) EXCEEDS .006 TIR - NOTIFY PLANNING FOR DISPOSITION.							
		SPLINE O.D. 7.735/7.740 ACROSS 0.4800 ROLL PINS SERVICE LIMIT 7.728 SPLINE O.D. 8.988/8.994 ACROSS 0.3840 ROLL PINS SERVICE LIMIT 8.980 SEAL GROOVE O.D. 7.244/7.247 WEAR 7.242							
		RECORD BASE METAL DIMENSION SEAL GROOVE WIDTH .579/.589/.750 BEARING SURFACE OD 7.720/7.722/7.718 (CONTINUED)							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21007N
		B	D	

## 21007N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 4 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SPLINED TUBE						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		RECORD BASE METAL DIM. *C/P MOVE*							
26	035	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
26	040	STRIP CAD *C/P MOVE					001 MNPRC 002 02 003 CS01		
26	045	STRIP RUST *C/P MOVE					001 MNPRC 002 02 003 CS02		
69	050	RECENTER ENDS *C/P MOVE					001 MNPRA 002 02 003 LE07		
69	060	NICK AND BURR REPAIR AS NECESSARY *C/P MOVE					001 MNPRA 002 02 003 BE01		
8	070	FIRST GRIND SEAL GROOVE MIN DIAMETER O.D. 7.220, MAX WIDTH .750. MAINTAIN CONCENTRICITIES. RECORD BASE METAL DIMENSION *C/P MOVE					001 MNPRB 002 03 003 GE05		
		[REDACTED]							
		TIME OUT _____ DATE OUT _____ *C/P MOVE				M	001 MNPNA 002 06 003 TE03		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21007N			
		B		D					

## 21007N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 5 OF 5 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		SPLINED TUBE							
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		*****							
26B	090	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH					001 MNPRC		
		DATE IN: TIME IN:					002 02		
		DATE OUT: TIME OUT:					003 BK01		
		*C/P MOVE							
		***** NOTE *****				M	001 MNPNA		
		IF LAST NDI OPERATION IS COMPLETED*					002 06		
		HERE, TAKE PRODUCTION COUNT					003 MLO4		
		*****							
26	103	VAPOR DEGREASE *C/P MOVE					001 MNPRC		
							002 03		
							003 DG01		
26	105	GRIT BLAST SPLINES TO REMOVE MINOR CORROSION/RIDGES NOT EXCEEDING .010 DEPTH					001 MNPRC		
		*C/P MOVE					002 01		
							003 BLO2		
26	107	SHOT PEEN SPLINES THAT HAVE BEEN GRIT BLASTED. SHOT PEEN .008-.012 A2					001 MNPRC		
		*C/P MOVE					002 01		
							003 SP02		
26	110	SHOT PEEN SEAL AREA AFTER NICK AND BURR .008-.012 A2					001 MNPRC		
		*C/P MOVE					002 01		
							003 SP02		
26	112	SHOT PEEN SEAL GROOVE .008-.012 A2					001 MNPRC		
		*C/P MOVE					002 01		
							003 SP02		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21007N			
		B		D					

## 21007N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 6 OF 6 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SPLINED TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26	120	PREPARE SEAL GROOVE FOR NICKEL PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BLO2		
26	125	PREPARE SEAL GROOVE FOR NICKEL PLATE, MASK/FIXTURE/ETC.					001 MNPRC 002 03 003 BE01 <del>005 X7222150</del>		
26	130	SULPHAMATE NICKEL PLATE SEAL GROOVE TYPE II SUFFICIENT TO GRIND BACK TO 7.244/7.247 WIDTH .579/.750					001 MNPRC 002 03 003 NP01 <del>005 X7222150</del>		
		TIME OUT _____ DATE OUT _____ *C/P MOVE					008 N0010		
26B	140	BAKE 24 HRS AT 350F TO 400F WITHIN 4 HRS OF NICKLE PLATE					001 MNPRC 002 02 003 BK01		
		DATE IN: _____ TIME IN: _____							
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE							
8	160	FINISH GRIND SEAL GROOVE FINISHED DIAMETER OD 7.244/7.247. WIDTH OF GROOVE .579/.750. MAINTAIN CONCENTRICITY OF .004 TO BEARING AREA O.D. 32 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS RECORD CRITICAL DIMENSION *C/P MOVE					001 MNPRB 002 03 003 GE05		
8	170	CHAMFER EDGES OF SEAL GROOVE .040-.050 X 43-47DEGREES IF NOT PREVIOUSLY ACCOMPLISHED *C/P MOVE					001 MNPRB 002 03 003 GE05		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21007N			
		B		D					

## 21007N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 7 OF 7 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		SPLINED TUBE							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
26B	189	BAKE 4 HRS AT 350/400 F TIME IN _____ DATE IN _____ TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****				M	001 MNPNA 002 06 003 MLO4		
26	193	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
26	197	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED *C/P MOVE					001 MNPRC 002 01 003 BL02		
26	200	CAD PLATE UPPER END AND UPPER END THREADS AND SEAL GROOVE FACES IF IF NICKLE PLATE IS NOT PRESENT TYPE II CLASS II TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CAD1		
26B	210	BAKE 24 HRS AT 350F TO 400F WITHIN 4 HRS OF CAD DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21007N			
		B		D					

168



## 21007N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 8 OF 8 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		SPLINED TUBE							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****				M	001 MNPNA 002 06 003 MLO4		
26B	217	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
26M	219	PRIOR TO PHOSPHATE, GRIT BLAST ALL AREAS TO BE PHOSPHATE COATED *C/P MOVE					001 MNPRC 002 01 003 BL02		
26	220	PHOSPHATE TREATMENT TYPE "M" ALL EXTERIOR SURFACES EXCEPT THREADS & SEAL GROOVE. *C/P MOVE					001 MNPRC 002 03 003 PH01		
26B	230	BAKE FOR 8 HRS AT 210F TO 225F DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE					001 MNPRC 002 02 003 BK02		
26	240	DRY FILM LUBE EXTERIOR PHOSPHATED AREA ONLY *C/P MOVE					001 MNPRC 002 03 003 EL01		
26B	250	BAKE FOR ONE HOUR AT 400F IAW MIL-L-46010 DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE					001 MNPRC 002 02 003 BK02		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21007N			
		B		D					

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
				21007N
		B	D	170

170

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
				MNP GP					
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO			
			4S-1-182						
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL AND SUPPLEMENTS			
C5A MAIN						17575A			
13. SERIAL NUMBER			14. NOUN						
			UPPER SIDE BRACE ARM						
15. DISPATCH STATION	16. PERFORM RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20.	
P/N		NSN C/N							
4G11436-107A		1620001157388 17575A						7	
		17577A						8	
		17578A							
		GOVERNING DIRECTIVES: AFLCR 66-51							
		BLAST IAW MANOI 66-3							
		FMPI IAW MIL-STD-1504							
		P/O NO1561							
		SHOT PEEN IAW MIL-S-13165							
		CAD PLATE IAW MIL-STD-870							
		BAKE IAW 4S-1-182							
		MAOI 74-12							
		TEMPER ETCH IAW MIL-STD-867							
		ALODINE IAW MIL-C-5541							
		IWD PLATE IAW MIL-C-22432A							
		***MAT'L STEEL 280-300 KSI 300M***							
		***COST = \$4235.36***							
		ALL PERSONNEL INVOLVED IN THE WORK							
		PROCESSES SPECIFIED IN THIS DOCUMENT							
		HAVE BEEN THOROUGHLY TRAINED AND ARE							
		FAMILIAR WITH ALL PERTINENT SAFETY							
		PRACTICES AND HAZARDS CONTAINED IN							
		THE BASIC TECHNICAL ORDER (T.O.) AND							
		T.O. SUPPLEMENTS REFERENCED IN BLOCK							
		8 OF THIS AFLC FORM 959. THE							
		APPLICABLE T.O.'S AND SUPPLEMENTS							
		WILL ALWAYS BE USED IN CONJUNCTION							
		WITH THIS DOCUMENT.							
		* COMPONENTS WILL BE THOROUGHLY							
		CLEANED & PROTECTED (C/P MOVE) FOR							
		MOVES BETWEEN OPERATIONS/DISPATCH							
		STATIONS.							
		WARNING							
		MANY OF THE FOLLOWING REPAIR							
		(CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21009N			
		B		D					

## 21009N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 2 OF 2 PAGES

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN UPPER SIDE BRACE ARM						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	4G11436-107A							
	005 *REQD*	DISASSEMBLE/REMOVE ALL BUSHINGS 100% REQUIRED DUE TO CORROSION.					001 MNP GP 002 01 003 SD03		
	*REQD*	CHEM CLEAN *C/P MOVE					001 MNP GW 002 03 003 SL01		
	*REQD*	BLAST CLEAN *C/P MOVE					001 MNP GW 002 03 003 BL01		
	*REQD*	BAKE 4 HRS AT 350-400F					001 MNP GW 002 03 003 BK03		
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
	*REQD*	*C/P MOVE				M	001 MNP NA 002 05 003 MS03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21009N			
		B		D					

172

## 21009N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 3 OF 3 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN UPPER SIDE BRACE ARM	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		E AND I INSPECTION.		001 MNPGW	
	*REQD*	BASE LUG ID 3.1995/3.2025/3.2045 WEAR		002 04	
		FACE TO FACE 8.243/8.247/8.249 WEAR		003 EI01	
		APEX LUG ID 2.9995/3.0025/3.0045 WEAR			
		FACE TO FACE 6.212/6.215/6.217 WEAR			
		OVERALL 9.475/9.465/9.463 WEAR			
		*NOTE: A MINIMUM OF 2 FMPI OPERATIONS MUST BE ACCOMPLISHED.			
		*C/P MOVE			
		NICK AND BURR REPAIR.			
		*C/P MOVE			
26	022	VAPOR DECREASE *C/P MOVE		001 MNPRC	
				002 03	
				003 D001	
26	024	STRIP CAD *C/P MOVE		001 MNPRC	
				002 02	
				003 CS01	
26	026	STRIP RUST *C/P MOVE		001 MNPRC	
				002 02	
				003 CS02	
69	030	BASE LUG HOLE REPAIR. LINE BORE MAX ID FOR SPARE BUSH 3.488 MAX ID FOR SPECIAL BUSH 3.570 - .694 MIN. WALL *C/P MOVE		001 MNPRA	
				002 03	
				003 MH04	
				004 X8433673	
69	035	BASE LUG FACE REPAIR MIN 1.41 *C/P MOVE		001 MNPRA	
				002 03	
				003 MH04	
				004 X8433673	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21009N
		B	D	

## 21009N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 4 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN					
				UPPER SIDE BRACE ARM					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
69	040	APEX LUG HOLE REPAIR LINE BORE MAX ID FOR SPARE BUSH 3.289 MAX ID FOR SPECIAL BUSH 3.370 .6515 MIN. WALL *C/P MOVE						001 MNPRA 002 03 003 MH04 005 X8533673	
69	045	APEX LUG FACE REPAIR MIN 1.33 *C/P MOVE						001 MNPRA 002 03 003 MH04 005 X8533673	
		ALL REWORKED AREAS TIME OUT _____ DATE OUT _____ *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****				M		001 MNPNA 002 06 003 TED3	
268	047	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH TIME IN _____ DATE IN _____ TIME OUT _____ DATE OUT _____ *C/P MOVE						001 MNPRA 002 02 003 BK01	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****				M		001 MNPNA 002 06 003 MLO4	
26	049	VAPOR DEGREASE *C/P MOVE						001 MNPRA 002 03 003 DG01	
26	050	SHOT PEEN ALL REWORKED AREAS .000/.012 A2 *C/P MOVE						001 MNPRA 002 01 003 SP02	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21009N			
		B		D					

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21006N
		B	D	16

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

21009N WORK CONTROL DOCUMENT (MEDS) 1 DATE 89040 PAGE 5 OF 5 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO
10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL		
13 SERIAL NUMBER	14 NOUN UPPER SIDE BRACE ARM			

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	051	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	052	CAD PLATE TYPE II CLASS II TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CAD1	
26B	053	BAKE 24 HRS AT 350F TO 400F WITHIN 4 HRS OF CAD PLATE. DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
26	054	IRIDITE-CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 IR01	
		***** NOTE ***** IF LAST MII OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****	M	001 MNPRA 002 06 003 ML04	
26	056	IVD PLATE (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 IVD1	
26	057	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 IVD1	
69	078	MACHINE BASE LUG BUSHING P/N 4613533-103A		001 MNPRA 002 02 003 LED2	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21009N
		B	D	175

AFLC FORM 958 NOV. 80 PREVIOUS EDITION WILL BE USED

## 21009N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 6 OF 6 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		UPPER SIDE BRACE ARM							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
69	080	BASE LUG BUSHING INSTALLATION. BRUSH CAD & INSTALL WITH MIL-C-16173D. FINISHED BUSHING DIA. ID 3.1995/3.2025 FACE TO FACE FLANGED BUSHING 8.243/8.247. OVERALL EACH LUG 1.490/1.505 63RMS *C/P MOVE RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS					001 MNPRA 002 02 003 BE01		
69	088	MACHINE APEX LUG BUSHING P/N 4613534-103A					001 MNPRA 002 02 003 LE02		
69	090	APEX LUG BUSHING INSTALLATION. BRUSH CAD AND INSTALL WITH MIL-C-16173D. FINISH BUSH DIA ID 3.9995/3.0005 FACE TO FACE INSIDE 8.212/8.215 OVERALL EACH LUG 1.605/1.640 63RMS *C/P MOVE RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS					001 MNPRA 002 02 003 BE01		
	095	PAINT *C/P MOVE					001 MNPGP 002 09 003 WB03		
	100	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958					001 MNPGP 002 01 003 MU06		
	110	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*					001 MNPGP 002 01 003 MU06		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21009N			
		B		D					



## 21011N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 1 OF 1 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
				MNP GP					
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
			4S-1-182						
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 SUPPLEMENTS			
CSA MLG						17575A			
13 SERIAL NUMBER			14 NOUN						
			HEADLESS PIN						
15 DISPATCH STATION	16 PERFORM NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19	20	
P/N 4G13646-103R		NSN C/N 5315001760762 17575A 17576A 17577A 17578A						7 8	
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 BAKE IAW 4S-1-182 MAOI 74-12							
		FMPI IAW MIL-STD-1949 P/O NO1561							
		CAD PLATE IAW MIL-STD-870 TP II CL II							
		IVD PLATE IAW MIL-C-83488A ALODINE IAW MIL-C-5541 *****AT'L 300 M 280,000-300,000KSI**							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		*****"M A R N I N G"*****							
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS (CONTINUED)							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				21011N			
		B							
		D							

177

## 21011N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 2 OF 2 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA			9. ITEM SERIAL NO

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN HEADLESS PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4G13646-103B			
	005	DISASSEMBLE *C/P MOVE		001 MNPBP	
	*REQD*			002 01	
				003 SD03	
		CHEM CLEAN *C/P MOVE		001 MNPBW	
	*REQD*			002 03	
				003 SLD1	
		BLAST CLEAN *C/P MOVE		001 MNPBW	
	*REQD*			002 03	
				003 BL07	
		BAKE 4HRS AT 350-400F		001 MNPBW	
	*REQD*	DATE IN _____ TIME IN _____		002 03	
		DATE OUT _____ TIME OUT _____		003 BK03	
		*C/P MOVE			
		*REQD*		001 MNPNA	
		*C/P MOVE		002 05	
				003 MS03	
		E & I CHECK PIN D.D.		001 MNPBW	
		1.372/1.373/1.3712 SERVICE		002 04	
				003 EID1	
26	032	VAPOR DEGREASE *C/P MOVE		001 MNPRC	
				002 03	
				003 DG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21011N
		B	D	

178

## 21011N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 3 OF 4 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO		

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN HEADLESS PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	034	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	036	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
26	038	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL04	
26	040	CAD PLATE ALL AREAS NOT CHROME PLATED. TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	050	BAKE 23 HRS AT 350-400F WITHIN 4HRS OF CAD. DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
26	060	IRIDITE *C/P MOVE		001 MNPRC 002 02 003 IR01	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****	M	001 MNPRC 002 06 003 ML04	
26	065	IVD PLATE (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 IVD1	

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
DISPATCH	A	21011N
FUNCTIONAL CODE	B	
	C	
	D	

179

## 21011N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 4 OF 4 PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA			9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOU HEADLESS PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	066	ALODINE IVD PLATED AREAS *C/P MOVE		001 MNP RC 002 03 003 TA01	
	067	DEGREASE & PRE-PAINT *C/P MOVE		001 MNP GP 002 09 003 PP01	
	068	PAINT *C/P MOVE		001 MNP GP 002 09 003 WB03	
	070	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958		001 MNP GP 002 01 003 MU06	
	080	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*		001 MNP GP 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21011N
		B	D	

## 21012N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 1 OF 1 PAGES

2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
				MNP GP					
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO.			
			491-93-3 & SUPPLEMENTS 46-1-182						
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
C-5A MLG						17575A 6			
13 SERIAL NUMBER			14 NOUN						
			LOWER PLATE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19.	20.	
P/N		NSN C/N							
4613558-101A		1620004212101 17575A 17576A 17577A 17578A						7 8	
		GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3							
		SHOTPEEN I A W MIL-S-12145							
		F.P.I. I A W MIL-STD-6866							
		ANODIZE I A W MIL-A-8625							
		ALODINE I A W MIL-C-5541							
		STRIP I A W MIL-STD-871							
		***MAT'L 7075-T73 A L U M I N U M***							
		ALL PERSONNEL INVOLVED IN THE WORK							
		PROCESSES SPECIFIED IN THIS DOCUMENT							
		HAVE BEEN THOROUGHLY TRAINED AND ARE							
		FAMILIAR WITH ALL PERTINENT SAFETY							
		PRACTICES AND HAZARDS CONTAINED IN							
		THE BASIC TECHNICAL ORDER AND T.O.							
		SUPPLEMENTS REFERENCED. THE APPLIC-							
		ABLE T.O.'S AND SUPPLEMENTS WILL							
		ALWAYS BE USED IN CONJUNCTION WITH							
		THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY							
		CLEANED AND PROTECTED (C/P MOVE) FOR							
		MOVES BETWEEN OPERATIONS/DISPATCH							
		STATIONS.							
		*****"W A R N I N G"*****							
		MANY OF THE FOLLOWING REPAIR							
		PROCEDURES REQUIRE THE USE OF							
		EQUIPMENT, PROCESSES, & CHEMICALS							
		WHICH ARE POTENTIALLY DANGEROUS TO							
(CONTINUED)									

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21012N	
		B	D		

## 21012N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN LOWER PLATE
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
--	--	---	--	--	--

		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
--	--	---	--	--	--

	001	4613558-101A			
--	-----	--------------	--	--	--

34C5	005	DISASSEMBLE *C/P MOVE		001 MNPBP	
	*REQD*			002 01	
				003 SD03	

34C	007	CHEM CLEAN *C/P MOVE		001 MNPBW	
	*REQD*			002 03	
				003 AC02	

34B	009	BLAST CLEAN *C/P MOVE		001 MNPBW	
	*REQD*			002 03	
				003 BL07	

		*C/P MOVE	M	001 MNPNA	
	*REQD*			002 05	
				003 ZY05	

34E	018	E & I BEARING BORE I.D 3.3465/3.3475/3.348		001 MNPBW	
	*REQD*	SHAFT HOLES I.D:		002 04	
		SMALL .7490-.7505		003 EID1	

		LARGE .8120-.8135 *C/P MOVE			
--	--	-----------------------------	--	--	--

34E	019	NICK & BURR REPAIR *C/P MOVE		001 MNPBW	
				002 04	
				003 EID1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21012N	
		B	D		

## 21012N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 3 OF 3 PAGES

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN LOWER PLATE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
69	040	SHAFT HOLE REPAIR (SMALL) OVERSIZE SMALL HOLE AS REQUIRED TO CLEAN UP .8305/.950 *C/P MOVE					001 MNPRA	002 04	
							003 MVO2	005 X8952120	
69	050	SHAFT HOLE REPAIR (LARGE) OVERSIZE LARGE HOLES AS REQUIRED TO CLEAN UP .8935/.950 *C/P MOVE					001 MNPRA	002 04	
							003 MVO2	005 X8952120	
69	060	BEARING BORE REPAIR OVERSIZE BEARING BORE AS REQUIRED TO CLEAN UP 3.650 MAX *C/P MOVE					001 MNPRA	002 04	
							003 MVO2	005 X8952120	
69	065	REMOVE INSERTS P/N MS124738 (4EA) & P/N 124736(4EA) ONLY IF ANODIZE STRIP IS REQUIRED. *C/P MOVE					001 MNPRA	002 02	
							003 BED1		
26	070	STRIP ANODIZE *C/P MOVE					001 MNPRC	002 03	
							003 AN04		
26A	080	FPI *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****				M	001 MNPNA	002 06	
							003 ZA02		
26	090	SHOTPEEN REWORKED AREAS .008-.010 A *C/P MOVE					001 MNPRC	002 01	
							003 SP01		
26	100	ANODIZE TYPE II *C/P MOVE					001 MNPRC	002 03	
							003 AS03		
26	110	ALODINE *C/P MOVE					001 MNPRC	002 03	
							003 TA01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21012N			
		B		D					

## 21012N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 4 OF 4 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN LOWER PLATE	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	118	MACHINE SHAFT HOLE BUSHING (SMALL) FROM 7075 T6 OR 6061 T6 ALUM		001 MNPRA 002 02 003 LE02	
69	120	INSTALL SHAFT HOLE REPAIR (SMALL) BUSHING. INSTALL WITH MIL-C-16173D COMPOUND .0003-.001 PRESS FIT. *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	121	MACHINE SHAFT HOLE BUSHING (SMALL) FINISH I.D. .7490/.7505		001 MNPRA 002 04 003 MU02 005 X8552123	
69	128	MACHINE SHAFT HOLE BUSHING (LARGE) FROM 7075-T6 OR 6061 T6 ALUM		001 MNPRA 002 02 003 LE02	
69	130	INSTALL SHAFT HOLE REPAIR (LARGE) BUSHING INSTALL WITH MIL-C-16173 PRESS FIT .0003-.001 .8120-.8135 *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	132	MACHINE SHAFT HOLE BUSHING (LARGE) FINISH I.D. .8120/8135		001 MNPRA 002 04 003 MU02 005 X8552123	
69	138	MACHINE BEARING BORE BUSHING FROM 7076-T6 OR 6061-T6 ALUM		001 MNPRA 002 02 003 LE02	
69	140	INSTALL BEARING BORE REPAIR BUSHING INSTALL WITH MIL-C-16173 COMPOUND .0003-.001 PRESS FIT		001 MNPRA 002 02 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21012N
		B	D	



## 21012N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89037

PAGE 5 OF 5 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN LOWER PLATE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
69	141	MACHINE BEARING BORE BUSHING FINISH I.D. 3.3465/3.3475 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE						001 MNPRA 002 04 003 MU02 <del>005 X0352123</del>	
69	145	INSTALL INSERTS (4 EA) *C/P MOVE P/N MS124736 P/N MS124738						001 MNPRA 002 02 003 BE01	
3405	150	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958						001 MNPSP 002 01 003 MU06	
3405	160	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE						001 MNPSP 002 01 003 MU06	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21012N			
		B		D					

145

## 21013N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 1 OF 1 PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC MNPGP	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 4S-1-182 4S1-22-2 AND SUPPLEMENTS	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES C5A MAIN	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN LOWER SIDE BRACE ARM	

15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
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P/N 4G11435-101A	NSN 1620001157387	C/N 17575A 17576A + 17577A 17578A		7 8	
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\*\*\*\*\* UNIT COST: \$4890.00 \*\*\*\*\*

GOVERNING DIRECTIVES: AFLOR 66-51  
MANOI 66-3

FMPI IAW MIL-STD-1242

P/O NO1561

SHOT PEEN IAW MIL-S-13165

CAD PLATE IAW MIL-STD-870

BAKE IAW 4S-1-182

MAOI 74-12

TEMPER ETCH IAW MIL-STD-867

BLAST IAW MIL-STD-1504

IND PLATE IAW MIL-C-93129A

ALDINE IAW MIL-C-5541

\*\*\*\*\*MAT'L 300 M 280-300 KSI\*\*\*\*\*

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.

\* COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.

WARNING  
MANY OF THE FOLLOWING REPAIR

(CONTINUED)

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/BN
DISPATCH FUNCTIONAL CODE	A C	21013N
	B D	

## 21013N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 2 OF 2 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN LOWER SIDE BRACE ARM	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4G11435-101A			
	005 *REQD*	DISASSEMBLE/REMOVE BUSHINGS 100% REQUIRED DUE TO CORROSION		001 MNPBP 002 01 003 SD03	
	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPBW 002 03 003 SL01	
	*REQD*	BLAST CLEAN *C/P MOVE		001 MNPBW 002 03 003 BL01	
	*REQD*	BAKE 4 HRS AT 350-400F		001 MNPBW 002 03 003 BK03	
		DATE IN _____ TIME IN _____			
		DATE OUT _____ TIME OUT _____ *C/P MOVE			
	*REQD*	*C/P MOVE	M	001 MNPNA 002 05 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21013N
		B	D	

## 21013N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 3 OF 4 PAGES

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO	
10. MODEL DESIGN SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN LOWER SIDE BRACE ARM						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		E AND I INSPECTION					001 MNPGW		
	*REQD*	BASE LUG BUSHINGS I.D. 4.499/4.502					002 04		
		WEAR 4.504					003 EI01		
		FACE TO FACE 8.243/8.249/8.251 WEAR							
		APEX LUG BUSHINGS I.D.							
		2.9995/3.0025 WEAR 3.0045							
		FACE TO FACE 2.626/2.630							
		NOTE: A MINIMUM OF TWO FMPI							
		OPERATIONS REQUIRED ON THIS PART.							
		*C/P MOVE							
		NICK AND BURR REPAIR							
		*C/P MOVE							
26	050	VAPOR DEGREASE				*C/P MOVE	001 MNPRC		
							002 03		
							003 DG01		
26	053	STRIP CAD				*C/P MOVE	001 MNPRC		
							002 02		
							003 CS01		
26	057	STRIP RUST				*C/P MOVE	001 MNPRC		
							002 02		
							003 CS02		
69	070	BASE LUG HOLE REPAIR					001 MNPRC		
		O/S TO CLEANUP 125 RMS MAX ID FOR					002 02		
		SPARE BUSH 4.807 MAX ID FOR SPECIAL					003 MH04		
		BUSH 4.940 - .800 MIN. WALL					005 X9133674		
		*C/P MOVE							
69	075	BASE LUG FACE REPAIR					001 MNPRC		
		MACH LUG FACE AS NECESSARY TO CLEAN					002 02		
		UP 1.27 MINIMUM 125RMS					003 MH04		
		(CONTINUED)					005 X9133674		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SV			
DISPATCH	FUNCTIONAL CODE	A		C		21013N			
		B		D					

## 21013N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 4 OF 4 PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN LOWER SIDE BRACE ARM	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 P	20 Q
		*C/P MOVE			
69	080	APEX LUG HOLE REPAIR OVERSIZE TO CLEANUP 125 RMS .76 MIN WALL *C/P MOVE		001 MNPRA 002 02 003 MH04 005 X8633674	
69	085	APEX LUG FACE REPAIR MACH LUG FACES AS NECESSARY TO CLEAN UP 1.36 MINIMUM 125RMS *C/P MOVE		001 MNPRA 002 02 003 MH04 005 X8633674	
		TIME OUT _____ DATE OUT _____ C/P MOVE	M	001 MNPNA 002 06 003 TE03	
		***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
26B	087	BAKE 4 HRS AT 350 TO 400F WITHIN 8 HRS OF ETCH DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNPRA 002 02 003 BK01	
		TIME OUT _____ DATE OUT _____ *C/P MOVE			
		***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M	001 MNPNA 002 06 003 ML04	
26	089	VAPOR DEGREASE *C/P MOVE		001 MNPRA 002 03 003 IG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21013N
		B	D	

## 21013N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 5 OF 5 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN LOWER SIDE BRACE ARM	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
26	090	SHOT PEEN ALL REWORKED AREAS INTENSITY OF .008/.012 A2 *C/P MOVE		001 MNPRC 002 01 003 SP02	
26	091	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL02	
26	092	CAD PLATE TYPE II CLASS II TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CAD1	
26B	093	BAKE 23 HOURS AT 350 TO 400F WITHIN 4 HOURS OF CAD PLATE DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE		001 MNPRC 002 02 003 BK01	
26	094	IRIDITE-CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 IRO1	
		*C/P MOVE ***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****	H	001 MNPRC 002 06 003 MLO4	
26	100	IVD PLATE (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 IVO1	
26	110	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 TAO1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21013N
		B	D	

## 21013N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 6 OF 6 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN LOWER SIDE BRACE ARM						
18 DISPATCH STATION	19 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
69	138	MACHINE BASE LUG BUSHING P/N 4013536-103A					001 MNPRA 002 02 003 LE02		
69	140	BASE LUG BUSHING INSTALLATION BRUSH CAD AND INSTALL WITH MIL-C-16173D ID 4.499/4.502 FACE TO FACE FOR FLANGED BUSH 8.243/8.249 OVERALL EACH LUG 1.501/1.490 63RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 02 003 BE01		
69	148	MACHINE APEX LUG BUSHING P/N 4013535-103A					001 MNPRA 002 02 003 LE02		
69	150	APEX LUG BUSHING INSTALLATION BRUSH CAD & INSTALL MIL-C-16173D FINISH BUSH ID 2.9995/3.0025 OVERALL FOR FLANGED BUSH 6.298/6.292 OVERALL EACH LUG 1.770/1.802 FACE TO FACE 2.630/2.626 63RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 02 003 BE01		
	155	PAINT *C/P MOVE					001 MNP GP 002 09 003 WB03		
	160	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958					001 MNP GP 002 01 003 MU06		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21013N			
		B		D					

PAGE 7 OF 7 PAGES

[illegible]192



## 21015N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 107 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
				MNP GP					
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO.			
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
CSA MAIN						4S-1-182 1C-5A-3 4S1-93-3 & SUPPLEMENTS			
13 SERIAL NUMBER			14 NOUN						
			YOKE						
15 DISPATCH STATION		16 PERF RCC/OP NO		17 WORK TO BE ACCOMPLISHED		18 MECHANIC		19 "P" "Q"	
P/N				NSN C/N					
4G11430-113B				1620001753939 17575A 17576A 17577A 17578A					
				***** UNIT COST: \$44029.41***** GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3					
				FRI IAW MIL-STD-6866					
				STRIP ANDDIZE IAW MIL-STD-871					
				SHOT PEEN IAW MIL-S-13165					
				ANDDIZE IAW MIL-A-8625					
				ALDINE IAW MIL-C-5541					
				BLAST IAW MIL-STD-1504					
				*****MATL: ALUMINUM 7075-T6***** ***** (H.T. T72) *****					
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. NOTE: TO DISTINGUISH RIGHT & LEFT FACE SIDE BRACE LUGS WITH YOKE UPRIGHT *****WARNING***** (CONTINUED)					
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/NO					
DISPATCH	FUNCTIONAL CODE	A	C	21015N					
		B	D						

## 21015N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 2 OF 2 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA		9 ITEM SERIAL NO	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN YOKE	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4G11430-113B			
	005 *REQD*	DISASSEMBLE -- NOTE: REMOVE ALL BALLSCREW BUSHINGS, UPPER AND LOWER DRAG SHAFT BUSHING, AND OBVIOUSLY WORN OR DAMAGED BUSHINGS. NOTE: THESE BUSHINGS MUST BE REMOVED DUE TO BASE METAL CORROSION *C/P MOVE		001 MNPBP 002 01 003 SD03	
		DEGREASE YOKE/CLEAN YOKE *REQD* *C/P MOVE		001 MNPBW 002 02 003 DG02	
		DIMENSIONAL CHECK/DETERMINE CENTER LINE SERVICABILITY 12.513-12.524 *REQD* SERVICE LIMIT 12.527 RECORD DIMENSION *C/P MOVE		001 MNPBW 002 04 003 E101	
69	008	REMOVE CENTER BORE LINER IF REQUIRED AND BUSHINGS THAT CANNOT BE REMOVED IN C5 AREA *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X823467	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21015N
		B	D	

## 21015N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN YOKE						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		BLAST TO REMOVE SEALANT FROM CENTERBORE AND YOKE COMPLETE *C/P MOVE					001 MNPBW 002 03 003 BL01		
		CHECK/MIC CENTER BORE BASE METAL 12.750-12.754 & DETERMINE BUSHING REMOVAL REQUIREMENTS. NOTE: IF CENTER BORE REQUIRES HONING, ALL BUSHINGS MUST BE REMOVED *C/P MOVE					001 MNPBW 002 04 003 EID1		
	011	REMOVE BUSHINGS AS INDICATED AND SCRAPE OFF REMAINING SEALANT FROM EDGES. *C/P MOVE					001 MNPBP 002 01 003 SD03		
	012	REMOVE INSERTS FROM CHAIN COVER HOLES IF REQUIRED. *C/P MOVE					001 MNPBP 002 01 003 SD03		
		BLAST YOKE AS REQUIRED NOTE: IF CENTER LINER WAS NOT REMOVED, MASK TO PREVENT DAMAGE. *C/P MOVE					001 MNPBW 002 03 003 BL01		
		STRIP ANODIZE IF REQ'D *C/P MOVE					001 MNPBW 002 03 003 AND3		
		*C/P MOVE				M	001 MNPNA 002 05 003 ZY05		
	*REQD*	E AND I INSPECTION					001 MNPBW 002 04 003 EID1		
	*REQD*	CENTER MOUNTING HOLE SLEEVE I.D. 12.512/12.524 WEAR 12.527 RECORD BASE METAL DIMENSION BALL SCREW BUSHINGS I.D. 3.756/3.759 WEAR 3.761 (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						21015N			

195

2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN YOKE						
15 DISPATCH STATION	16 PERP RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		BASE METAL 4.100 MAX I.D. RECORD BASE METAL DIMENSION LEFT RIGHT							
		UPPER SIDE BRACE BUSHINGS I.D. 3.199/3.202 WEAR 3.204 BASE METAL 3.570 MAX I.D. RECORD BASE METAL DIMENSION							
		LOWER SIDE BRACE BUSHINGS I.D. 4.499/4.502 WEAR 4.504 BASE METAL 4.870 MAX I.D. RECORD BASE METAL DIMENSION							
		TRUNNION END BUSHINGS I.D. 6.6245/6.6275 WEAR 6.629 BASE METAL 6.993 MAX I.D. RECORD BASE METAL DIMENSION							
		RIGHT LEFT TRUNNION CROSS HOLE BUSHINGS I.D. 2.253/2.255 WEAR 2.257 BASE METAL 2.540 MAX I.D. RECORD BASE METAL DIMENSION							
		RIGHT LEFT RETAINER BOLT BUSHINGS I.D. 2.3745/2.3775 WEAR 2.385 BASE METAL .625 MAX I.D. *C/P MOVE							
69	035	NICK AND BURR REPAIR AS NECESSARY *C/P MOVE					001 MNFRA 002 02 003 BE01		
69	037	REPAIR DAMAGED THREADS IN CHAIN COVER HOLES AS INDICATED					001 MNFRA 002 02 003 BE01		
		NOTE: HOLES ARE NUMBERED 1-6 STARTING IN UPPER L/H HOLE AND GOING COUNTER CLOCKWISE. *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21015N			
		B		D					

## 21015N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 5 OF 5 PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
------------------------	-----------------	-------------

13 SERIAL NUMBER	14 NOUN YOKE
------------------	-----------------

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
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69	040	REPAIR CRACK IN CHAIN COVER HOLES AS INDICATED IAW IC-5A-3 SECTION 5 *C/P MOVE		001 MNPRA 002 02 003 BED1	
----	-----	--	--	---------------------------------	--

		INSURE REMOVAL OF CRACK IF NECESSARY. *C/P MOVE	M	001 MNPNA 002 05 003 ZY05	
--	--	--	---	---------------------------------	--

8	050	HONE I.D. OF CENTER BORE TO TRUE UP 12.750/12.754 RECORD DIM _____ *C/P MOVE		001 MNPRA 002 01 003 HV03	
---	-----	---	--	---------------------------------	--

69	055	MACHINE BALLSCREW FACE (LEFT SIDE) TO REMOVE DAMAGE OR CORROSION IAW FIGURE 5-49. *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8622667	
----	-----	--	--	---	--

69	060	MACHINE BALLSCREW FACE (RIGHT SIDE) TO REMOVE DAMAGE OR CORROSION IAW FIGURE 5-49. *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8622667	
----	-----	---	--	---	--

69	070	BALLSCREW HOLE (LEFT SIDE) REPAIR MACHINE HOLE TO CLEANUP; DO NOT EXCEED MAX I.D. 4.100 RECORD BASE METAL DIMENSION _____ *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8622667	
----	-----	---	--	---	--

69	080	BALL SCREW HOLE (RIGHT SIDE) REPAIR MACHINE HOLE TO CLEANUP NOT TO EXCEED MAX I.D. 4.100 RECORD BASE METAL DIMENSION _____ *C/P MOVE		001 MNPRA 002 02 003 MH05 005 X8622667	
----	-----	--	--	---	--

69	090	UPPER SIDE BRACE HOLE REPAIR O/S HOLE TO CLEANUP, NOT TO EXCEED 3.570 MAX ID MIN LUG WALL OF (CONTINUED)		001 MNPRA 002 02 003 BED1	
----	-----	---	--	---------------------------------	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21015N	
		B	D		

## 21015N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 6 OF 6 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN YOKE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19. P	20. Q	
		1.1113 RECORD BASE METAL DIMENSION *C/P MOVE							
69	100	LOWER SIDE BRACE HOLE REPAIR O/S HOLE TO CLEANUP, NOT TO EXCEED 4.870 MAX ID MIN LUG WALL OF 1.8313 RECORD BASE METAL DIMENSION *C/P MOVE					001 MNPRA 002 02 003 BE01		
69	110	TRUNNION END HOLE (LEFT SIDE) HOLE REPAIR. MACHINE HOLE TO CLEANUP, NOT TO EXCEED I.D. 6.993 MAINTAIN EXISTING RADIUS RECORD BASE METAL DIMENSION *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X8-38667		
69	120	TRUNNION END HOLE (RIGHT SIDE) REPAIR. MAINTAIN HOLE TO CLEANUP, NOT TO EXCEED I.D. 6.993 MAINTAIN EXISTING RADIUS RECORD BASE METAL DIMENSION *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X8-38667		
69	130	TRUNNION CROSS PIN HOLE (LEFT SIDE) REPAIR. O/S HOLES IN LINE TO CLEANUP, NOT TO EXCEED I.D. 2.560 RECORD BASE METAL DIMENSION *C/P MOVE					001 MNPRA 002 02 003 BE01		
69	140	TRUNNION CROSS PIN HOLE (RIGHT SIDE) O/S HOLES IN LINE TO CLEANUP NOT TO EXCEED I.D. 2.560. (CONTINUED)					001 MNPRA 002 02 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21015N			
		B		D					

## 21015N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 7 OF 7 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN YOKE						
18 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		RECORD BASE METAL DIMENSION *C/P MOVE							
69	150	RETAINER BOLT HOLE (LEFT SIDE) REPAIR. LINE REAM AND ROLL BURNISH TO CLEANUP, NOT TO EXCEED I.D. .625 *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X8332667		
69	160	RETAINER BOLT HOLE (RIGHT SIDE) REPAIR. LINE REAM AND ROLL BURNISH TO CLEANUP, NOT TO EXCEED I.D. .625 *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X8332667		
69	165	BALLSCREW SPROCKET BORE _____ SIDE REPAIR. MACHINE BORE TO CLEAN-UP 2.350 MAX I.D. .800/.825 LENGTH *C/P MOVE					001 MNPRA 002 02 003 MH05 005 X8332667		
26	180	VAPOR DECREASE *C/P MOVE					001 MNPRA 002 03 003 0601		
26	190	SHOTPEEN YOKE COMPLETE INTENSITY OF .010/.014 A INCLUDING ALL HOLES AND LUGS OVER 2 INCHES *C/P MOVE					001 MNPRA 002 01 003 SP01		
26	200	SHOTPEEN REWORKED AREAS. INTENSITY OF .010/.014 A *C/P MOVE					001 MNPRA 002 01 003 SP01		
26	205	SHOTPEEN I.D. OF CENTER BORE IF REWORKED INTENSITY .010/.014A *C/P MOVE					001 MNPRA 002 01 003 SP01		
26	210	POLISH LUG HOLES THAT HAVE BEEN SHOTPEENED. LIGHTLY POLISH TO REMOVE SHOTPEEN ROUGHNESS, DO NOT REMOVE MORE THAN .002 MATERIAL *C/P MOVE					001 MNPRA 002 03 003 BE01		

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21015N	
		B	D		

## 21015N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 8 OF 8 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCT/ON SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN YOKE						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
8	215	HONE I.D. OF CENTER BORE AFTER SHOTPEEN 12.750/12.754 64 RMS. RECORD DIM. .... *C/P MOVE					001 MNPRB 002 01 003 HV03		
26	220	ANODIZE YOKE COMPLETE. TYPE II *C/P MOVE					001 MNPRC 002 03 003 AS03 004 Y7722155		
26	222	ALODINE REWORKED LOCAL AREAS *C/P MOVE					001 MNPRC 002 03 003 TA01 004 Y7722155		
69	225	INSTALL INSERT IN REPAIRED HOLES P/N MS21208-F4-20 *C/P MOVE					001 MNPRA 002 02 003 BE01		
69	230	CENTER MOUNTING HOLE SLEEVE INSTALLATION (SUB ZERO SHRINKING). USE SLEEVE P/N 469449-101A INSTALL WITH PR1431G TPI, P/S 8700-12 OR PR-4400 C-12. SWAG THE UPPER END OF SLEEVE WITH SWAGING TOOL P/N 12560237 .013- .014 PRESS FIT I.D. DIMENSION 12.511/12.524 RECORD I.D. DIMENSION *C/P MOVE					001 MNPRA 002 02 003 BE01		
69	238	MACHINE BALLSCREW HOLE BUSHING (LEFT SIDE) *C/P MOVE P/N 4619063-107A					001 MNPRA 002 02 003 LE02		
69	240	BALLSCREW HOLE BUSHING (LEFT SIDE) INSTALLATION. P/N 4619063-107A .0015 PRESS FIT INSTALL WITH XIL-C-14172D, GRADE 2 AND 2 FINISH BUSHING ID 3.756/3.759 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE (CONTINUED)					001 MNPRA 002 02 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21015N			
		B		D					



## 21015N WORK CONTROL DOCUMENT (MEDS)

11 DATE

89035

PAGE 9 OF 9 PAGES

2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN YOKE					
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
		EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE							
69	248	MACHINE BALLSCREW HOLE BUSHING (RIGHT SIDE) *C/P MOVE P/N 4619063-107A					001 MNPRA 002 02 003 LE02		
69	250	BALLSCREW HOLE BUSHING (RIGHT SIDE) INSTALLATION. P/N 4619063-107A .0015/.0035 PRESS FIT INSTALL WITH MIL-C-16173D GRADE 2 AND 2 FINISH BUSHING ID 3.756/3.759 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 02 003 BE01		
69	259	MACHINE UPPER SIDE BRACE HOLE BUSHING *C/P MOVE P/N 4613592-103A (6 EA) P/N 4613449-105A (2 EA)					001 MNPRA 002 02 003 LE02		
69	260	UPPER SIDE BRACE HOLE BUSHING INSTALLATION. USE BUSHING P/N 4613592-103A (6 EA) AND BUSHING P/N 4613449-105A (2 EA) .0015/.0035 PRESS FIT INSTALL WITH MIL-C-16173D, GRADE 2, AND 2 FINISH BUSHING ID 3.199/3.202 OVERALL 2.740/2.746 FACE TO FACE 1.506/1.509 125 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 02 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21015N			
		B		D					

## 21015N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 10 OF 10 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN YOKE	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. P	20. O
69	269	MACHINE LOWER SIDE BRACE HOLE BUSHING P/N 4G13593-103A (6 EA) P/N 4G13650-105A (2 EA) *C/P MOVE		001 MNPRA 002 02 003 LE02	
69	270	LOWER SIDE BRACE HOLE BUSHING INSTALLATION. USE BUSHING P/N 4G13593-103A (6 EA) AND BUSHING P/N 4G13650-105A (2 EA) .0015/.0025 PRESS FIT. FINISH BUSHING I.D. 4.499/4.502 125 RMS INSTALL BUSHINGS WITH MIL-C-16173D, GRADE 2 AND 2 FACE TO FACE 1.506/1.509 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	278	MACHINE TRUNNION END HOLE BUSHING (LEFT SIDE) P/N 4G13595-103A *C/P MOVE		001 MNPRA 002 02 003 LE02	
69	280	TRUNNION END HOLE (LEFT SIDE) BUSH INSTALLATION. P/N 4G13595-103A MACHINE FOR A .0025/.0055 PRESS FIT INSTALL WITH MIL-C-16173D, GRADE 2 AND 2. MAINTAIN BUSHING FLANGE THICKNESS OF .200 MAX FINISH BUSH ID 6.6245/6.6275 125 RMS OVERALL 74.394/74.460 CHAMFER CROSS BOLT HOLES 35 TO 40 DEG X .040 RECORD OVERALL DIM RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS		001 MNPRA 002 02 003 BE01	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21015N
		B	D	

102

## 21015N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 11 OF 11 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN YOKE	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
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		*C/P MOVE			
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69	288	MACHINE TRUNNION END HOLE BUSHING (RIGHT SIDE) *C/P MOVE P/N 4G13595-103A		001 MNPRA 002 02 003 LE02	
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69	290	TRUNNION END HOLE (RIGHT SIDE) BUSH P/N 4G13595-103A MACHINE FOR A .0025/.0055 PRESS FIT. INSTALL WITH MIL-C-16173D GRADE 2, AND 2.		001 MNPRA 002 02 003 BE01	
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		MAINTAIN BUSH FLANGE THICKNESS OF .200 MAX FINISH BUSHING I.D. 6.6245/6.6275 125 RMS OVERALL 74.394/74.440			
--	--	---	--	--	--

		CHAMFER CROSS BOLT HOLES 35 TO 40 DEG X .040 RECORD OVERALL DIMENSION OF TRUNNION BUSHING			
--	--	--	--	--	--

		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS			
--	--	--	--	--	--

		*C/P MOVE			
--	--	-----------	--	--	--

69	295	IF NOT PREVIOUSLY ACCOMPLISHED, MIC AND RECORD OVERALL DIM. OF TRUNNION BUSHINGS *REQD* *C/P MOVE		001 MNPRA 002 02 003 BE01	
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69	298	MACHINE TRUNNION CROSS PIN HOLE BUSHING (LEFT SIDE) *C/P MOVE P/N 4G13597-103A		001 MNPRA 002 02 003 LE02	
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69	300	TRUNNION CROSS PIN HOLE (LEFT SIDE) BUSHING INSTALLATION. USE BUSHING P/N 4G13597-103A .0025/.0055		001 MNPRA 002 02 003 BE01	
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(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21015N
		B	D	

105

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN YOKE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		PRESS FIT INSTALL WITH MIL-C-16173D, GRADE 2 AND 2 FINISH BUSHING I.D. 2.253/2.255 OVERALL 10.750/10.760 125 RMS							
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
		*C/P MOVE							
69	308	MACHINE TRUNNION CROSS PIN HOLE BUSHING (RIGHT SIDE) *C/P MOVE P/N 4G13597-103A						001 MNPRA 002 02 003 LE02	
69	310	TRUNNION CROSS PIN HOLE (RT SIDE) BUSHING INSTALLATION. USE BUSH P/N 4G13597-103A .0025/.0055 PRESS FIT INSTALL WITH MIL-C-16173D GRADE 2, AND 2 FINISH BUSHING I.D. 2.253/2.255 OVERALL 10.750/10.760 125 RMS						001 MNPRA 002 02 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
		*C/P MOVE							
69	318	MACHINE RETAINER BOLT HOLE BUSHING (LEFT SIDE) *C/P MOVE P/N 4G13729-103A						001 MNPRA 002 02 003 LE02	
69	320	RETAINER BOLT HOLE (LEFT SIDE) BUSHING INSTALLATION. BUSHING P/N 4G13729-103A .001/.002 PRESS FIT. INSTALL WITH MIL-C-16173D, GRADE 2, AND 2. FINISH BUSHING I.D. .3745/ .3775						001 MNPRA 002 02 003 BE01	
		RECORD WEAR DIM IF REWORK LIMITS ARE (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21015N			
		B		D					

## 21015N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 13 OF 13 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		YOKE							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
69	324	*C/P MOVE MACHINE RETAINER BOLT HOLE BUSHING (RIGHT SIDE) *C/P MOVE P/N 4613729-103A					001 MNPRA 002 02 003 LE02		
69	325	RETAINER BOLT HOLE (RT SIDE) BUSHING INSTALLATION. P/N 4613729-103A .001/.002 PRESS FIT INSTALL WITH MIL C-16173B, GRADE 2 AND 2 FINISH BUSHING ID .3745/.3775 125 RMS PRODUCTION COUNT 60110					001 MNPRA 002 02 003 BE01		
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED							
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
		*C/P MOVE							
69	326	MACHINE BALLSCREW SPROCKET SLEEVE FROM 6061-T6 OR EQUAL LENGTH .795/.800 PRESS FIT .005/.008 *C/P MOVE					001 MNPRA 002 02 003 LE02		
69	327	INSTALL BALLSCREW SPROCKET SLEEVE I.D. 9.251/9.2535 64 RMS BRUSH ALODINE AFTER FINAL MACHINE *C/P MOVE					001 MNPRA 002 02 003 BE01		
69	329	MANUFACTURE REPAIR MEMBER #5 IAW T.O 1C-5A-3 SEC 5 FIG 5-17 *C/P MOVE*					001 MNPRA 002 02 003 LE02		
69	330	INSTALL REPAIR MEMBERS 1,2,3,4,5, & 6 IAW T.O. 1C-5A-3 SEC 5 FIG 5-17 *C/P MOVE*					001 MNPRA 002 02 003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21015N			
		B		D					

205



2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
				MNP GP					
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
			45-1-182						
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL AND SUPPLEMENTS			
CSA MLG						17575A			
13 SERIAL NUMBER			14 NOUN						
			POSITIONING COLLAR						
15 DISPATCH STATION		16 PERF RCC/OP NO		17 WORK TO BE ACCOMPLISHED		18 MECHANIC		19 P	
P/N				NSN C/N				20	
4011476-107A				1620005581485 17575A				7	
4011476-101B				1620001157415 17576A				8	
				17577A					
				17578A					
				***** UNIT COST: \$9145.37 *****					
				GOVERNING DIRECTIVES: AFLOR 66-51					
				MANDI 66-3					
				PLAST IAW MIL-STD-1504					
				FMPJ IAW MIL-STD-1949					
				P/O N01561					
				STRIP CHROME IAW MIL-STD-871					
				GRIND IAW MIL-STD-844					
				TEMPER ETCH IAW MIL-STD-867					
				SHOT PEEN IAW MIL-S-12165					
				FPI IAW MIL-STD-6868					
				CAD PLATE IAW MIL-STD-870					
				CHROME PLATE IAW MIL-STD-1504					
				TP II CL III P/O N01891					
				BAKE IAW 45-1-182					
				MANDI 74-12					
				IVD PLATE IAW MIL-C-834284					
				ALODINE IAW MIL-C-5541					
				***** 300M 280/300 KSI *****					
				ALL PERSONNEL INVOLVED IN THE WORK					
				PROCESSES SPECIFIED IN THIS DOCUMENT					
				HAVE BEEN THOROUGHLY TRAINED AND ARE					
				FAMILIAR WITH ALL PERTINENT SAFETY					
				PRACTICES AND HAZARDS CONTAINED IN					
				BASIC TECHNICAL ORDER (T.O.) AND					
				T.O. SUPPLEMENTS REFERENCED. THE					
				APPLICABLE T.O.'S AND SUPPLEMENTS					
				WILL ALWAYS BE USED IN CONJUNCTION					
				WITH THIS DOCUMENT.					
				* COMPONENTS WILL THOROUGHLY					
				(CONTINUED)					
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN					
DISPATCH		FUNCTIONAL CODE		A		C		21016N	
				B		D			

## 21016N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN POSITIONING COLLAR						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 MO	
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	4G11476-107A 4G11476-101B							
	005	DISASSEMBLE *C/P MOVE					001 MNPGP		
	*REQD*						002 01		
							003 SD03		
		CHEN CLEAN *C/P MOVE					001 MNPGW		
	*REQD*						002 03		
							003 SL01		
		BLAST CLEAN *C/P MOVE					001 MNPGW		
	*REQD*						002 03		
							003 BL01		
		BAKE 4 HRS AT 350-400F					001 MNPGW		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
							003 BK03		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21016N			
		B		D					



## 21016N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN POSITIONING COLLAR						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
		*C/P MOVE				M	001 MNPNA		
	*REQD*						002 05		
							003 MS03		
		E AND I INSPECTION					001 MNPBW		
	*REQD*	COLLAR I.D. 9.4542/9.4562					002 04		
							003 EID1		
		COLLAR THICKNESS 3.055 MINIMUM							
		POSITIONER LUG BUSHING I.D.							
		2.249/2.2514 WEAR 2.2529							
		FACE TO FACE I.D. 2.875/2.879							
		WEAR 2.8805							
		CLEVIS LUG BUSHINGS (R&L) I.D.							
		.249/.251 WEAR .2525							
		FACE TO FACE I.D. .341/.348							
		WEAR .3495							
		BASE METAL REWORK SIZES AS FOLLOWS:							
		POSITIONER LUG HOLE MAX I.D. 2.550							
		OR MIN WALL OF .500							
		CLEVIS LUG HOLES MAX I.D. .412 OR							
		MIN LUG WALL OF .120							
		***** G T *****							
		INSURE ALL TEETH HAVE BEEN CHAMFERED							
		IF NOT, ROUTE FOR OPERATIONS 090 AND							
		/OR 095 *C/P MOVE							
		LOCAL REWORK COLLAR FACE MAX.							
		DEPTH OF 0.060 X 0.75 IN. SQ.							
		PER 90 DEGREE QUADRANT.							
		*C/P MOVE							
		REMOVE BUSHINGS					001 MNPBW		
		*C/P MOVE					002 04		
							003 EID1		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21016N			
		B		D					

## 21016N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 4 OF 4 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN POSITIONING COLLAR	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
26	047	VAPOR DECREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
26	050	STRIP CAD *C/P MOVE		001 MNPRC 002 02 003 CS01	
26	052	STRIP RUST *C/P MOVE		001 MNPRC 002 02 003 CS02	
69	055	REMOVE PINS P/N 4G13312-101A *C/P MOVE *REGO*		001 MNPRA 002 02 003 BE01	
69	060	POSITIONER LUG HOLE REPAIR. LINE BORE OR HONE TO CLEANUP NOT TO EXCEED ID 2.550 OR MIN LUG WALL THICKNESS OF .500 *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	070	CLEVIS LUG HOLE (LEFT SIDE) REPAIR LINE REAM HOLES TO CLEANUP, NOT TO EXCEED ID .412 OR LUG WALL OF .120 *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	080	CLEVIS LUG HOLE (RIGHT SIDE) REPAIR LINE REAM HOLES TO CLEANUP, NOT TO EXCEED ID .412 OR LUG WALL OF .149 *C/P MOVE		001 MNPRA 002 02 003 BE01	
8	090	MACHINE TOP OF ALL SMALL TEETH .015/ .020 BELOW THE TOP OF THE TWO LARGE TEETH AND CHAMFER EDGES OF SMALL TEETH 45 (+OR- 5 DEG) BY .010 TO .060 MAINTAIN 3.055 MINIMUM OVERALL DIMENSION AS MEASURED FROM TOP OF LARGE TEETH TO CHAMFER FACE.		001 MNPRC 002 02 003 DJ02	
8	095	CHAMFER BOTH EDGES OF THE TWO LARGE TEETH 15 (+OR- 5 DEG) BY .125 - .150 *C/P MOVE		001 MNPRC 002 02 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21016N
		B	D	

## 21016N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 5 OF 5 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		POSITIONING COLLAR							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
26	098	VAPOR DEGREASE *C/P MOVE					001 MNPFC 002 03 003 D601		
26	100	STRIP CHROME FROM COLLAR FACE *C/P MOVE					001 MNPFC 002 02 003 3002		
26	110	STRIP CHROME FROM COLLAR INSIDE *C/P MOVE					001 MNPFC 002 02 003 5002		
8	120	FIRST GRIND COLLAR FACE. CLEANUP FOR CHROME, NOT TO EXCEED MIN THICKNESS OF 3.050 FROM DATUM PLANE A *C/P MOVE					001 MNPFC 002 01 003 6104 005 12745144		
8	130	FIRST GRIND COLLAR INSIDE. CLEANUP FOR CHROME OR TO REMOVE OLD CHROME, NOT TO EXCEED I.D. 9.472 *C/P MOVE					001 MNPFC 002 01 003 6104 005 12745144		
		[REDACTED]				M	001 MNPFC 002 03 003 T603		
		TIME OUT: _____ DATE OUT: _____ *C/P MOVE							
		***** N O T E ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****							
26B	150	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH *C/P MOVE					001 MNPFC 002 02 003 BK01		
		DATE IN: _____ TIME IN: _____							
		DATE OUT: _____ TIME OUT: _____							
		[REDACTED] *C/P MOVE				M	001 MNPFC 002 06 003 MLO4		
		***** N O T E ***** IF LAST NDI OPERATION IS COMPLETED* (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21016N			
		B		D					

## 21016N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 6 OF 8 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN POSITIONING COLLAR						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		HERE, TAKE PRODUCTION COUNT *****							
26	165	VAPOR DEGREASE *C/P MOVE						001 MNPRC 002 03 003 1601	
26	170	SHOT PEEN COLLAR FACE FOR CHROME INTENSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26	180	SHOT PEEN COLLAR INSIDE FOR CHROME INTENSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26	190	SHOT PEEN REMOVED AREAS INTENSITY OF .008/.012 A2 *C/P MOVE						001 MNPRC 002 01 003 SP02	
26	192	PREPARE COLLAR FACE FOR CHROME PLATE, GRIT BLAST *C/P MOVE						001 MNPRC 002 01 003 BL02	
26	197	PREPARE COLLAR FACE FOR CHROME PLATE, MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED-----						001 MNPRC 002 02 003 BE01 005 XTE22147	
26	200	CHROME PLATE COLLAR FACE SUFFICIENT TO GRIND BACK TO 3.065/3.075 FROM DATUM PLANE A						001 MNPRC 002 02 003 CP01 005 XTE22147	
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED----- *C/P MOVE						008 C0010	
26B	202	BAKE 4 HRS AT 350F - 400F WITHIN 4 HRS OF CHROME						001 MNPRC 002 02 003 BK01	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21016N	
		B	D		

212

## 21016N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 7 OF 7 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN POSITIONING COLLAR						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	204	PREPARE COLLAR I.D. FOR CHROME PLATE. GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 SL02		
26	206	PREPARE COLLAR INSIDE FOR CHROME PLATE. MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED					001 MNPRC 002 02 003 BE01 005 X7532147		
26	210	CHROME PLATE COLLAR INSIDE SUFFICIENT TO GRIND BACK TO 9.4542/9.4562					001 MNPRC 002 00 003 0101 005 X7532147		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED *C/P MOVE					008 01010		
207	220	GRIND & HRS AT EDGE TO 400V WITHIN 4 THS OF CHROME *C/P MOVE					001 MNPRC 002 02 003 BE01		
		DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____							
8	230	FINISH GRIND COLLAR, FACE FINISHED THICKNESS TO BE 3.065 ±.075 FROM DATUM PLANE A. MAINTAIN PARALLELISM & STRAIGHTNESS .0005 *C/P MOVE					001 MNPRC 002 01 003 0104 005 X8745164		
8	240	FINISH GRIND COLLAR INSIDE. FINISHED DIA ID 9.4542/9.4562 MAINTAIN STRAIGHTNESS & CONCENTRICITIES (CONTINUED)					001 MNPRC 002 01 003 0104 005 X8745164		
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21016N			
		B		D					

213

## 21016N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 8 OF 8 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN		15					
		POSITIONING COLLAR							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 T	
		ACRMS *C/P MOVE							
25B	250	BAKE 4 HRS AT 350F TO 400F DATE IN: TIME IN: DATE OUT: TIME OUT: *C/P MOVE						001 BNPRC 002 02 003 BK01	
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****						001 BNPRC 002 02 003 BK01	
26	265	VAPOR DECREASE *C/P MOVE						001 BNPRC 002 02 003 BK01	
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****						001 BNPRC 002 02 003 BK01	
26	275	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE						001 BNPRC 002 01 003 BL02	
26	280	CAD PLATE TYPE II CLASS II TIME OUT: DATE OUT: (CONTINUED)						001 BNPRC 002 03 003 CA01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21016N	
		B	D		

214

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NGUN POSITIONING COLLAR							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		*C/P MOVE							
268	290	BAKE 23 HRS AT 350F TO 400F WITHIN 4 HRS OF CAD PLATE DATE IN: TIME IN: DATE OUT: TIME OUT: *C/P MOVE						001 MNPRC 002 02 003 BK01	
26	295	(IRIDITE) CHROMATE CONVERSION COATING						001 MNPRC 002 02 003 IR01	
		*C/P MOVE ***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****						001 MNPRC 002 06 003 AL04	
26	301	IVD PLATE (INITIATED BY PLATING) *NOTE* IF CHROME PLATE REWORK WAS ACCOMPLISHED, OPERATION 290 MUST BE DONE PRIOR TO IVD PLATING *C/P MOVE						001 MNPRC 002 03 003 IVD1	
26	302	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE						001 MNPRC 002 03 003 IVD1	
69	303	MACHINE AND FACE PINS .290/.295 FROM FACE OF SMALL LUGS I.A.W. DWG 4611476 *C/P MOVE (CONTINUED)						001 MNPRC 002 02 003 LE02	
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21016N			
		B		D					

## 21016N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 10 OF 10 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN POSITIONING COLLAR							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		P/N 4613312-101A							
69	305	INSTALL PINS I.A.W. T.O. *C/P MOVE *RECD+ P/N 4613312-101A					001 MNPRA 002 02 003 BED1		
69	308	MACHINE POSITIONER LUG BUSHING *C/P MOVE P/N 4613610-103A					001 MNPRA 002 02 003 LED2		
69	310	POSITIONER LUG BUSHING INSTALLATION USE BUSHING P/N 4613610-103A PRESS FIT .0017/.003. USE SEALING COMPOUND MIL-C-16173D. FINISH BUSHING DIA ID 2.249/2.2514. FACE TO FACE INSIDE 2.875/2.879. 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED					001 MNPRA 002 02 003 BED1		
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE							
69	318	MACHINE CLEVIS LUG HOLE BUSHINGS (LEFT SIDE) *C/P MOVE P/N 4613338-103A P/N 4613609-103A					001 MNPRA 002 02 003 LED2		
69	320	CLEVIS LUG HOLE (LEFT SIDE) BUSHING INSTALLATION USE BUSHING P/N 4613338-103A & P/N 4613609-103A PRESS FIT .0005/.002. USE SEALING COMPOUND MIL-C-16173D. FINISH BUSHING DIA ID .249/.2514. FACE TO FACE INSIDE .341/.348. 63 RMS					001 MNPRA 002 02 003 BED1		
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21016N			
		B		D					



## 21016N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 11 OF 11 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		POSITIONING COLLAR							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		REWORK LIMITS *C/P MOVE							
69	328	MACHINE CLEVIS LUG HOLE BUSHINGS (RIGHT SIDE) *C/P MOVE P/N 4613338-103A P/N 4613609-103A					001 MNPRA 002 02 003 LE02		
69	330	CLEVIS LUG HOLE (RIGHT SIDE) BUSHING INSTALLATION USE BUSHINGS P/N 4613338-103A & P/N 4613609-103A PRESS FIT					001 MNPRA 002 02 003 BE01		
		.0005/.002. USE SEALING COMPOUND HIL-C-161730 FINISH DIA I.D. .249/.2514 FACE TO FACE INSIDE .241/.242 ARMS							
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
		*C/P MOVE							
	335	PAINT IAW 451-93-3 & 45-1-182 *C/P MOVE					001 MNP6P 002 09 003 WB03		
	340	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 953					001 MNP6P 002 01 003 FA05		
	350	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*					001 MNP6P 002 01 003 FA05		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21016N			
		B		D					

## 21017N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 1 OF 1 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNP GP		

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
	45-1-182	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL AND SUPPLEMENTS
------------------------	-----------------	-----------------------------

05A MAIN

13 SERIAL NUMBER	14 NOUN
	APEX SHAFT

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
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P/N

4613561-101A

NSN

5315001321925

C/N

17575A

17576A

17577A

17578A

\*\*\*\*\* UNIT COST: 4387.65 \*\*\*\*\*

GOVERNING DIRECTIVES: AFLCR 66-51

MANOI 66-3

ALODINE IAW MIL-C-5541

FMPT IAW MIL-STD-1949

P/O N01561

BAKE IAW 45-1-182

MANOI 74-12

GRIND IAW MIL-STD-888

TEMPER ETCH IAW MIL-STD-867

SHOT PEEN IAW MIL-E-13166

CAD PLATE IAW MIL-STD-820

CHROME PLATE IAW MIL-STD-1501

TP II CL III P/O N61891

FPI IAW MIL-STD-6886

TUD PLATE IAW MIL-E-824822

STRIP CHROME IAW MIL-STD 871

\*\*\*MAT/L: 300M 280,000-300,000 KSI

ALL PERSONNEL INVOLVED IN THE WORK

PROCESSES SPECIFIED IN THIS DOCUMENT

HAVE BEEN THOROUGHLY TRAINED AND ARE

FAMILIAR WITH ALL PERTINENT SAFETY

PRACTICES AND HAZARDS CONTAINED IN

THE BASIC TECHNICAL ORDER (T.O.) AND

T.O. SUPPLEMENTS REFERENCED. THE

APPLICABLE T.O.'S AND SUPPLEMENTS

WILL ALWAYS BE USED IN CONJUNCTION

WITH THIS DOCUMENT.

\* COMPONENTS WILL BE THOROUGHLY

CLEANED &amp; PROTECTED (C/P MOVE) FOR

MOVES BETWEEN OPERATIONS/DISPATCH

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21017N
		B	D	

## 21017N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO.		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN APEX SHAFT						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		<p>WARNING</p> <p>MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES &amp; CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.</p> <p>*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.</p>							
	001	4613561-101A							
	005 *REQD*	DISASSEMBLE *C/P MOVE					001 MNP GP 002 01 003 SB03		
	*REQD*	CHEM CLEAN *C/P MOVE					001 MNP GW 002 03 003 SL01		
	*REQD*	BLAST CLEAN *C/P MOVE					001 MNP GW 002 03 003 BL07		
	*REQD*	BAKE 4 HRS AT 350-400F					001 MNP GW 002 03 003 BK03		
		DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21017N			
		B		D					

## 21017N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 3 OF 3 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN APEX SHAFT						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE				M	001 MNPNA		
	*REQD*						002 05		
							003 MS03		
		E AND I INSPECTION SHAFT OD 2.2465/2.2485 WEAR 2.2455 NOTE: A MINIMUM OF TWO FMPI'S ARE REQUIRED ON THIS ITEM *C/P MOVE					001 MNPBW		
	*REQD*						002 04		
							003 EI01		
26	035	VAPOR DEGREASE *C/P MOVE					001 MNPBC		
							002 03		
							003 BG01		
26	040	STRIP OAD *C/P MOVE					001 MNPBC		
							002 02		
							003 CS01		
26	045	STRIP RUST *C/P MOVE					001 MNPBC		
							002 02		
							003 CS02		
26	050	STRIP CHROME FROM SHAFT *C/P MOVE					001 MNPBC		
							002 02		
							003 SC02		
69	055	RECENTER IF REQUIRED *C/P MOVE					001 MNPRA		
							002 02		
							003 LE09		
8	060	FIRST GRIND SHAFT MINIMUM GRIND SIZE O.D. 2.2335 63RMS MAINTAIN EXISTING RADIUS. *C/P MOVE					001 MNPBR		
							002 02		
							003 GE01		
		TIME OUT _____ DATE OUT _____ *C/P MOVE				M	001 MNPNA		
							002 06		
							003 TE03		

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21017N	
		B	D		

## 21017N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 4 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN APEX SHAFT					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *							
26E	080	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH DATE IN: _____ TIME IN: _____					001 MNPRC 002 02 003 BK01		
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE							
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *				n	001 MNPRC 002 06 003 ML04		
26	095	VAPOR DECREASE *C/P MOVE					001 MNPRC 002 03 003 BD01		
26	100	SHOT PEEN SHAFT INTENSITY OF .008/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	103	PREPARE SHAFT FOR CHROME PLATE MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED----- *C/P MOVE					001 MNPRC 002 02 003 BE01		
26	107	PREPARE SHAFT FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26	110	CHROME PLATE SHAFT SUFFICIENT TO GRIND BACK TO 2.2465/2.2485					001 MNPRC 002 02 003 CP01 004 CD010		
(CONTINUED)									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21017N			
		B		D					

## 21017N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 5 OF 5 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN APEX SHAFT						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
		DATE OUT: _____ TIME OUT: _____ MECHANIC SIGN OFF REQUIRED: _____ *C/P MOVE							
26B	120	BAKE 4 HRS AT 350F TO 400F WITHIN 4 HRS OF CHROME PLATE.						001 MNPFC 002 02 003 BK01	
		DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE							
8	130	FINISH GRIND SHAFT FINISHED DIAMETER O.D. 2.2465/2.2485. MAINTAIN EXISTING RADIUS .63 RMS RECORD REAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE						001 MNPFB 002 02 003 BE01	
26B	140	BAKE 4 HRS AT 350F TO 400F						001 MNPFC 002 02 003 BK01	
		DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE							
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****				M		001 MNPNA 002 06 003 ML04	
26	155	VAPOR DEGREASE						001 MNPFC 002 03 003 DG01	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21017N			
		B		D					

221

## 21017N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 6 OF 6 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN APEX SHAFT					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****				M	001 MNPNB 002 06 003 ZS01		
26	165	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE					001 MNPRC 002 01 003 BL02		
26	170	CAD PLATE SHAFT TYPE II CLASS II TIME OUT: _____ DATE OUT: _____ *C/P MOVE					001 MNPRC 002 03 003 CL01		
26B	180	BAKE 23 HRS AT 350F TO 400F WITHIN 4 HRS OF CAD PLATE DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE					001 MNPRC 002 02 003 BR01		
26	190	(IRIDITE) CHROMATE CONVERSION *C/P MOVE					001 MNPRC 002 02 003 IR01		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****				M	001 MNPNB 002 06 003 ZL04		
26	201	IVD PLATE (INITIATED BY PLATING) *NOTE* IF CHROME PLATE REWORK WAS ACCOMPLISHED, OPERATION 160 MUST (CONTINUED)					001 MNPRC 002 03 003 IV01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21017N			
		B		D					

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		APEX SHAFT							
15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		BE DONE PRIOR TO IVD OPTION. *C/P MOVE							
26	202	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE					001 HNPFC 002 03 003 TAO1		
	205	PAINT IAW 4S1-93-3 & 4S-1-162 *C/P MOVE					001 HNPFP 002 09 003 MB03		
	210	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958					001 HNPFP 002 01 003 MU06		
	220	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*					001 HNPFP 002 01 003 MU06		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21017N			
		B		D					



## 21018N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 1 OF 1 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
				MNP GP					
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
			45-1-182						
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
C5A MAIN						17575A			
13 SERIAL NUMBER			14 NOUN						
			RETRACT ARM						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19	20	
P/N		NSN C/N							
401144B-107A		1620001157390 17575A							
		17576A							
		17577A							
		17578A							
		***** UNIT COST: \$5008.00 *****							
		GOVERNING DIRECTIVES: AFLOR 66-51							
		MANO1 66-3							
		ALODINE IAW MIL-C-5541							
		FMPI IAW MIL-STD-1949							
		P/O R01561							
		STRIP CHROME IAW MIL-STD-871							
		GRIND IAW MIL-STD-866							
		TEMPER ETCH IAW MIL-STD-867							
		SHOT PEEN IAW MIL-S-13165							
		CHROME PLATE IAW MIL-STD-150							
		TYPE II CLASS 111 P/C 461891							
		CAD PLATE IAW MIL-STD-870							
		FPI IAW MIL-STD-4866							
		BAKE IAW 45-1-182							
		MANO1 74-12							
		IVD PLATE IAW MIL-C-23488A							
		MAT'L 300 M 280,000 300,000 KSI							
		ALL PERSONNEL INVOLVED IN THE WORK							
		PROCESSES SPECIFIED IN THIS DOCUMENT							
		HAVE BEEN THOROUGHLY TRAINED AND ARE							
		FAMILIAR WITH ALL PERTINENT SAFETY							
		PRACTICES AND HAZARDS CONTAINED IN							
		THE BASIC TECHNICAL ORDER (T.O.) AND							
		T.O. SUPPLEMENTS REFERENCED. THE							
		APPLICABLE T.O.'S AND SUPPLEMENTS							
		WILL ALWAYS BE USED IN CONJUNCTION							
		WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY							
		CLEANED & PROTECTED (C/P MOVE) FOR							
		MOVES BETWEEN OPERATIONS/DISPATCH							
(CONTINUED)									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21018N			
		B		D					

224

## 21018N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 2 OF 2 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN RETRACT ARM	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		STATIONS.			
		WARNING			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4011440-107A			
	005	DISASSEMBLE *C/P MOVE		001 BRP0F	
	*REQD*			002 01	
				003 BR03	
		CHEM CLEAN *C/P MOVE		001 BRP0W	
	*REQD*			002 03	
				003 BR03	
		BLAST CLEAN *C/P MOVE		001 BRP0W	
	*REQD*			002 03	
				003 BR03	
		BAKE 4 HRS AT 350-400F		001 BRP0W	
	*REQD*	DATE IN _____ TIME IN _____		002 03	
				003 BR03	
		DATE OUT _____ TIME OUT _____			
		*C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21018N
		B	D	

225

## 21018N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 3 OF 3 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN RETRACT ARM						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		[REDACTED] RC/P MOVE				M	001 MNPRA	002 05	
	*REQD*						003 ML04		
		E AND I INSPECTION					001 MNPBW	002 04	
	*REQD*	ARM SHAFT I.D. 6.622/6.624					003 EI01		
		WEAR 6.221							
		CROSS PIN HOLE I.D. 2.253/2.255							
		WEAR 2.257							
		SMALL ARM BUSHING I.D. 1.351/1.353							
		WEAR 1.3545							
		LARGE ARM BUSHING I.D. 2.251/2.253							
		WEAR 2.2545							
		FACE TO FACE 1.502/1.505							
		RIG PIN HOLE 1.500/1.505 RC/P MOVE							
		NOTE: A MINIMUM OF TWO FBPI'S ARE REQUIRED ON THIS ITEM.							
		REMOVE BUSHINGS					001 MNPBW	002 04	
		RC/P MOVE					003 EI01		
26	045	VAPOR DECREASE RC/P MOVE					001 MNPBC	002 03	
							003 CS01		
26	050	STRIP CAD RC/P MOVE					001 MNPBC	002 02	
							003 CS01		
26	055	STRIP RUST RC/P MOVE					001 MNPBC	002 02	
							003 CS02		
69	060	CROSS PIN HOLE REPAIR					001 MNPRA	002 02	
		MAX HOLE SIZE I.D. 2.465/2.445					003 MH04	005 Y8633449	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21018N
		B	D	

226

## 21018N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 4 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN RETRACT ARM						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		MAX COUNTER ROPE SIZE 1.0. 2.820 *C/P MOVE							
69	065	REPAIR RIG PIN HOLE BY BORING HOLE TO 3557.570 *C/P MOVE					001 MNFRA 002 0 003 001		
69	070	SMALL ARM HOLE REPAIR MAX 1.0. 1.750 *C/P MOVE					001 MNFRA 002 02 003 0002		
69	080	LARGE ARM HOLE REPAIR MAX 1.0. 2.650 *C/P MOVE					001 MNFRA 002 02 003 0002		
76	085	HAPOR DEGREASE *C/P MOVE					001 MNFRA 002 02 003 0001		
76	090	CIRIP LINGRE FROM ARM SHAFT *C/P MOVE					001 MNFRA 002 02 003 0002		
80	100	FIRST GRIND ARM SHAFT MIN SIZE D.D. 6.610 *C/P MOVE					001 MNFRA 002 03 003 0001		
		TIME OUT _____ DATE OUT _____ *C/P MOVE				m	001 MNFRA 002 06 003 0001		
		***** NOTE ***** IF LAST MBI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****							
26B	120	BAKE 4 HRS AT 350F TO 400F WITHIN 8 HRS OF ETCH (CONTINUED)					001 MNFRA 002 02 003 BR01		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21018N	
		B	D		

## 21018N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 5 OF 5 PAGES

2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER			12 OPTIONAL				
13 SERIAL NUMBER		14 NOUN RETRACT ARM							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18 MECHANIC	19. "P"	20. "Q"	
		DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****				M	001 MNPRC 002 06 003 MLO4		
26	131	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DB01		
26	132	SHOT PEEN CROSS PIN HOLE .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	134	SHOT PEEN SMALL ARM HOLE .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	136	SHOT PEEN LARGE ARM HOLE .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP01		
26	137	SHOT PEEN ARM SHAFT *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	138	PREPARE ARM SHAFT FOR CHROME PLATE, MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 03 003 BE01		
26	139	PREPARE ARM SHAFT FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21018N	
		B	D		

220

## 21018N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 6 OF 6 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN RETRACT ARM	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	140 ✓	CHROME PLATE ARM SHAFT SUFFICIENT TO GRIND BACK TO 6.622/6.624 (APPLY MINIMUM AMOUNT OF CHROME)		001 MNPRC 002 02 003 CF01 004 BK01	
		DATE OUT: _____ TIME OUT: _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE			
26B	150	BAKE 4 HRS AT 350F TO 400F WITHIN 4 HRS OF CHROME		001 MNPRC 002 02 003 BK01	
		DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
26	160	FINISH GRIND ARM SHAFT 63 RMS FINISH SIZE O.D. 6.602/6.624 RECORD WEAR DIA IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRC 002 03 003 BK01	
26B	170	BAKE 4 HRS AT 350F TO 400F		001 MNPRC 002 02 003 BK01	
		DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
		*C/P MOVE		001 MNPRC 002 03 003 ML04	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *			
		*****			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21018N
		B	D	

229

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## 21018N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 7 OF 7 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN RETRACT ARM	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "O"
26	185	VAPOR DECREASE *C/P MOVE		001 MNPRC 002 03 003 DG01	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****	M	001 MNPNA 002 06 003 ZG01	
26	195	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED		001 MNPRC 002 01 003 BL02	
26	200	CADMIUM PLATE TYPE II CLASS II TIME OUT: _____ DATE OUT: _____ *C/P MOVE		001 MNPRC 002 03 003 CA01	
26B	210	BAKE 20 HRS AT 350F TO 400F WITHIN 4 HRS OF CAD DATE IN: _____ TIME IN: _____		001 MNPRC 002 02 003 BR01	
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
26	215	(IRIDITE)CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 IR01	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****	M	001 MNPNA 002 06 003 ML04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21018N
		B	D	

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN RETRACT ARM						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
26	222	IVD PLATE (INITIATED BY PLATING) *NOTE* IF CHROME PLATE REWORK WAS ACCOMPLISHED, OPERATION 210 MUST BE DONE PRIOR TO IVD OPTION. *C/P MOVE					001 MNPRC 002 03 003 IVD1		
26	224	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE					001 MNPRC 002 03 003 TH01		
69	228	MACHINE LARGE ARM HOLE BUSHINGS *C/P MOVE P/N 4613530-105A					001 MNPRA 002 03 003 LE02		
69	230	LARGE ARM HOLE BUSHING INSTALLATION P/N 4613550-105A FACE TO FACE 1.532/1.535					001 MNPRA 002 03 003 BE01		
69	232	MACHINE LARGE ARM HOLE BUSHINGS FINISH ID 2.251/2.253 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE					001 MNPRA 002 03 003 M04 005 25130-63		
69	238	MACHINE SMALL ARM HOLE BUSHING *C/P MOVE P/N 4613529-103A					001 MNPRA 002 03 003 LE02		
69	240	SMALL ARM HOLE BUSHING INSTALLATION P/N 4613529-103A FACE TO FACE 1.532/1.535 *C/P MOVE					001 MNPRA 002 03 003 BE01		
69	242	MACHINE SMALL ARM HOLE BUSHING FINISH ID 1.351/1.353 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE (CONTINUED)					001 MNPRA 002 03 003 M04 005 25130-63		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21018N			
		B		D					



## 21018N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 9 OF 10 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN RETRACT ARM	

15 DISPATCH STATION	16 PERP RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS			
69	248	MACHINE CROSS BOLT HOLE BUSHING MANUFACTURE IAW 451-93-3 *C/P MOVE		001 MN2RA 002 02 003 LE02	
69	249	CROSS BOLT HOLE BUSHING INSTALLATION INSTALL IN ACCORDANCE WITH 451-93-3 *C/P MOVE		001 MN2RA 002 02 003 BE01	
69	250	MACHINE CROSS BOLT HOLE BUSHING FINISH ID 2.253/2.255 63 RMS RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS		001 MN2RA 002 02 003 RH04 004 28133003	
69	251	MACHINE RIG PIN BUSHING HEAT TREAT 180-200KSI *C/P MOVE P/N 66035001-03ST02		001 MN2RA 002 02 003 LE02	
69	252	INSTALL RIG PIN BUSHING P/N 66035001-03ST02 .0005-.001 PRESS FIT *C/P MOVE		001 MN2RA 002 02 003 BE01	
69	253	MACHINE RIG PIN BUSHING FINISH ID .500/.505 *C/P MOVE		001 MN2RA 002 02 003 RH04 004 28133003	
	255	DEGREASE & PRE-PAINT *C/P MOVE		001 MN2GP 002 09 003 PP01	
	260	PAINT IAW 45-1-182 & 451-93-3 *C/P MOVE		001 MN2GP 002 09 003 WB03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21018N
		B	D	

232

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN RETRACT ARM						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
	270 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MRPT 002 01 003 MU06		
	280 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MRPT 002 01 003 MU06		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21018N			
		B		D					

## 21019N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89061

PAGE 1 OF 1 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNPOR	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 40-1-162 401-99-3-4-10 SUPPLEMENTS	9 ITEM SERIAL NO
---------------	--	------------------

10 MODEL-DESIGN-SERIES C5A MAIN	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN TRUNNION PTM	17575A 72F52A

18. DISPATCH STATION	19. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	MECHANIC	19. "P"	20. "Q"
P/R 4012400-101A		NSN C/N 1620001162095 17575A 17576A 17577A 17578A 72852A	7 8		
		GOVERNING DIRECTIVES: AFLOR 66-61 MANDI 66-3 FMPI IAW MIL-STD-1949 P/O NO1561			
		BAKE IAW 40-1-102 NAOI 74-12			
		STRIP CHROME IAW MIL-STD-871			
		BRIND IAW MIL-STD-866			
		TEMPER ETCH IAW MIL-STD-867			
		SHOIPREN IAW MIL-8-13165			
		CAD PLATE IAW MIL-STD-870			
		CHROME PLATE IAW MIL-STD-1501			
		TP II CL II P/O NO1591			
		FPI IAW MIL-STD 6866			
		IVO PLATE IAW MIL-C-83488A			
		ALODINE IAW MIL-C-5541			
		**MAT'L: 300M 200,000-300,000 KSI** ***COST: \$1199.25***			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFCD FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		* COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED FOR MOVES			
		(CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21019N
		B	D	

## 21019N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89061

PAGE 2 OF 2 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN TRUNNION PIN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		(C/P MOVE) BETWEEN OPERATIONS AND DISPATCH STATIONS. WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	00124. 101A			
	005	DISASSEMBLE *C/P MOVE		001 MNPBP 002 01 003 S003	
		CHEM CLEAN *C/P MOVE		001 MNPBW 002 03 003 CL01	
		BLAST CLEAN *C/P MOVE		001 MNPBW 002 03 003 BL01	
		BAKE 4 HRS AT 350-400F		001 MNPBW 002 03 003 BK03	
	*REQD*	DATE IN _____ TIME IN _____			
		DATE OUT _____ TIME OUT _____ *C/P MOVE			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21019N
		B	D	

235

## 21019N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89061

PAGE 3 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN TRUNNION PIN						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		[REDACTED] *C/P MOVE				M	001 MNPNA 002 05 003 MS03		
		E AND I INSPECTION *REDD* PIN OD 6.623/6.624 WEAR 6.6225					001 MNPBW 002 04 003 EI01		
		CROSS BOLT HOLE ID 2.563/2.565 PIN ID 5.873/5.880 WEAR 5.882 NOTE: A MINIMUM OF TWO EMP'S ARE REQUIRED ON THIS PART. *C/P MOVE							
		REMOVE BUSHINGS					001 MNPBW 002 04 003 EI01		
		CROSS BOLT HOLES REPAIR (FOR DEFECT REMOVAL) NICK & BURR HOLES IAW FIG 5-20 *C/P MOVE					001 MNPBW 002 04 003 EI01		
26	044	VAPOR DECREASE *C/P MOVE					001 MNPBC 002 03 003 IG01		
26	046	STRIP CAD *C/P MOVE					001 MNPBC 002 02 003 CS01		
26	048	STRIP RUST *C/P MOVE					001 MNPBC 002 02 003 CS02		
26	050	STRIP CHROME FROM OUTSIDE *C/P MOVE					001 MNPBC 002 02 003 SC02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21019N			
		B		D					

236

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN TRUNNION PIN						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
26	060	STRIP CHROME FROM INSIDE *C/P MOVE					001 MNPRC 002 02 003 BC02 005 0702123		
8	070	FIRST GRIND O.D. MIN REWORK 6.609. MAINTAIN CONCENTRICITIES 125 RMS *C/P MOVE					001 MNPRB 002 02 003 BE01		
8	080	FIRST GRIND I.D. MAX REWORK 5.893. MAINTAIN CONCENTRICITIES IAW FIG 5-20 125 RMS *C/P MOVE					001 MNPRB 002 02 003 G105 005 X0745142		
8	085	POLISH I.D. MAX REWORK 5.893. MAINTAIN CONCENTRICITIES IAW FIG 5-20 125 RMS					001 MNPRB 002 02 003 BE01		
		[REDACTED]					001 MNPRB 002 06 003 IE03		
		TIME OUT: _____ DATE OUT: _____ * C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *							
26B	100	BAKE 4 HOURS AT 350 TO 400F WITHIN 8 HRS OF ETCH					001 MNPRC 002 02 003 BK01		
		DATE IN: _____ TIME IN: _____							
		DATE OUT: _____ TIME OUT: _____ * C/P MOVE							
		[REDACTED]					001 MNPRB 002 06 003 ML04		
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT. *							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21019N			
		B		D					

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN TRUNNION PIN						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
26	115	VAPOR DECREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
26	120	SHOT PEEN PIN REWORKED AREAS INTENSITY OF .008/.012 * C/P MOVE					001 MNPRC 002 01 003 SP02		
26	123	PREPARE PIN OUTSIDE FOR CHROME PLATE, MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED----- *C/P MOVE					001 MNPRC 002 02 003 BE01		
26	127	PREPARE PIN O.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26	130	CHROME PLATE PIN OUTSIDE ✓ SUFFICIENT TO GRIND BACK TO O.D. 6.623/6.624					001 MNPRC 002 02 003 CP01 004 CG01		
		DATE OUT: _____ TIME OUT: _____ MECHANIC SIGN OFF REQUIRED----- *C/P MOVE							
26B	131	BAKE 4 HOURS AT 350 TO 400F WITH 4 HRS OF CHROME					001 MNPRC 002 02 003 BK01		
		DATE IN: _____ TIME IN: _____							
		DATE OUT: _____ TIME OUT: _____ * C/P MOVE							
B	132	FINISH GRIND PIN O.D. 6.623/6.624. MAINTAIN CONCENTRICITIES 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS (CONTINUED)					001 MNPRB 002 02 003 GE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21019N			
		B		D					

## 21019N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89061

PAGE 6 OF 6 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN TRUNNION PIN						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		*C/P MOVE							
26B	133	BAKE 4 HRS AT 350 TO 400F DATE IN:-----TIME IN:----- DATE OUT:-----TIME OUT:----- *C/P MOVE					001 MNPRC 002 02 003 BK01		
26	135	PREPARE PIN I.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 IL02		
26	137	PREPARE PIN INSIDE FOR CHROME PLATE, MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED----- *C/P MOVE					001 MNPRC 002 01 003 BK01 004 X8722122		
26	140	✓ CHROME PLATE PIN INSIDE SUFFICIENT TO GRIND BACK TO I.D. 5.875 DATE OUT:-----TIME OUT:----- MECHANIC SIGN OFF REQUIRED----- *C/P MOVE					001 MNPRC 002 02 003 BK01 004 X8722122 008 01010		
26B	150	BAKE 4 HOURS AT 350 TO 400F WITH 4 HRS OF CHROME DATE IN:-----TIME IN:----- DATE OUT:-----TIME OUT:----- *C/P MOVE					001 MNPRC 002 02 003 BK01		
8	170	FINISH GRIND PIN I.D. 5.878/5.880 MAINTAIN CONCENTRICITIES. 63 RMS (CONTINUED)					001 MNPRB 002 02 003 GI05 005 X8745162		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21019N			
		B		D					

239



## 21019N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89061

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		TRUNNION PIN							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		RECORD WEAR DIM IF REMARK LIMITS ARE EXCEEDED. RECORD REASON & CAUSE FOR EXCEEDING REMARK LIMITS *C/P MOVE							
26B	180	BAKE 4 HRS AT 350 TO 400F  DATE IN:-----TIME IN:-----  DATE OUT:-----TIME OUT:----- *C/P MOVE							
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST HOT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *					001 MNPR 002 02 003 BK01		
26	195	VAPOR DEGREASE *C/P MOVE							
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST HOT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *					001 MNPR 002 02 003 BK01		
26	205	PRIOR TO CAD IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21019N			
		B		D					

## 21019N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89061

PAGE 8 OF 8 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN TRUNNION PIN						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
26	210	CAD PLATE TYPE II CLASS II TIME OUT: _____ DATE OUT: _____ * C/P MOVE						001 MRPAC 002 03 003 0001	
262	220	BAKE 24 HOURS AT 350 TO 400F WITHIN 4 HRS OF CAD DATE IN: _____ TIME IN: _____						001 MRPAC 002 02 003 0001	
		DATE OUT: _____ TIME OUT: _____ * C/P MOVE							
26	230	(IRIDITE) CHROMATE CONVERSION COATING *C/P MOVE						001 MRPAC 002 03 003 1001	
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST HOT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT. *****						001 MRPAC 002 03 003 0001	
26	240	IVD PLATE (INITIATED BY PLATING) *NOTE* IF CHROME PLATE REWORK WAS ACCOMPLISHED, OPERATION 200 MUST BE DONE PRIOR TO IVD OPERATION *C/P MOVE						001 MRPAC 002 03 003 1001	
26	241	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE						001 MRPAC 002 03 003 1001	
26	242	PAINT IAW 45-1-182 & 451-93-3 *C/P MOVE						001 MRPAC 002 03 003 WBOC	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21019N	
		B	D		

241

## 21019N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89061

PAGE 7 OF 9 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		TRUNNION PIN							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
	245	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNPBP 002 01 003 FA05		
	250	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNPBP 002 01 003 FA05		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21019N			
		B		D					

242

## 21020N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 1 OF 1 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNPGP		

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
	45-1-182 45-1-182-2 AND SUPPLEMENTS	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
CSA MAIN		

13 SERIAL NUMBER	14 NOUN
	ANTI-ROTATION BOLT

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19	20
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P/N 4612423-101A	NSN 1620001177319	C/N 17575A 17576A 17577A 17578A			6 7 8
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		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FMPI IAW MIL-STD-1949 P/O N01561			
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		BAKE IAW 45-1-182 MAOI 74-12 GRIND IAW MIL-STD-866 TEMPER ETCH IAW MIL-STD-867			
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		SHOT PEEN IAW MIL-S-13155 CAD PLATE IAW MIL-STD-870 CHROME PLATE IAW MIL-STD-1501 TP II CL III P/O N41821			
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		FPI IAW MIL-STD-886 STRIP CHROME IAW MIL-STD 871 IVD PLATE IAW MIL-C-88488A ALODINE IAW MIL-C-5541			
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		***MAT'L 300M 280,000-300,000 KSI** ***COST: \$205.09***			
--	--	---	--	--	--

		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN			
--	--	--	--	--	--

		THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFIC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS			
--	--	---	--	--	--

		WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. * COMPONENTS WILL BE THOROUGHLY (CONTINUED)			
--	--	---	--	--	--

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
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DISPATCH	FUNCTIONAL CODE	A	C	21020N
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		B	D	
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## 21020N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 2 OF 2 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
---------------	-------------	-------------------

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN ANTI-ROTATION BOLT	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4612433-101A			
	005 *REQD*	DISASSEMBLE *C/P MOVE		001 MNPBP 002 01 003 SD03	
	*REQD*	CHEM CLEAN *C/P MOVE		001 MNPBW 002 03 003 SL01	
	*REQD*	BLAST CLEAN *C/P MOVE		001 MNPBW 002 03 003 BL07	
	*REQD*	BAKE 4 HRS AT 350-400F		001 MNPBW 002 03 003 BK03	
		DATE IN _____ TIME IN _____ *C/P MOVE			
		DATE OUT _____ TIME OUT _____			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21020N
		B	D	

## 21020N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 3 OF 3 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ANTI-ROTATION BOLT						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		[REDACTED] *C/P MOVE				H	001 MNPNA 002 05 003 HEC3		
	*REQD*								
		E AND I INSPECTION BOLT SHANK O.D. 1.622/1.623 WEAR 1.621 *C/P MOVE					001 MNPBW 002 04 003 EID1		
26	025	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DGO1		
26	030	STRIP CAD *C/P MOVE					001 MNPRC 002 02 003 CS01		
26	035	STRIP RUST *C/P MOVE					001 MNPRC 002 02 003 CS02		
26	040	STRIP CHROME FROM BOLT SHANK *C/P MOVE					001 MNPRC 002 02 003 SC02		
8	050	FIRST GRIND BOLT SHANK. MIN GRIND SIZE OD 1.609. MAINTAIN EXISTING RADIUS 63 RMS *C/P MOVE					001 MNPRC 002 01 003 GEC0		
		[REDACTED] *C/P MOVE				M	001 MNPNA 002 06 003 TED3		
		TIME OUT _____ DATE OUT _____ ***** NOTE *****							
		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****							
26B	070	BAKE 4 HOURS AT 350 TO 400F WITHIN 8 HRS OF ETCH *C/P MOVE					001 MNPRC 002 02 003 BK01		

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21020N	
		B	D		

## 21020N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 4 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN ANTI-ROTATION BOLT							
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		DATE IN: _____ TIME IN: _____							
		DATE OUT: _____ TIME OUT: _____							
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****				M	001 MNPRC 002 06 003 ML04		
26	085	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 BG01		
26	090	SHOT PEEN BOLT SHANK INTENSITY OF .008/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	093	PREPARE BOLT SHANK FOR CHROME PLATE, MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED-----> *C/P MOVE					001 MNPRC 002 02 003 BE01		
26	097	PREPARE BOLT SHANK FOR CHROME PLATE GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL04		
26	100	CHROME PLATE BOLT SHANK SUFFICIENT TO GRIND BACK TO O.D. 1.622/1.623					001 MNPRC 002 02 003 CP01 008 CD10		
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED-----> *C/P MOVE							
26B	110	BAKE 4 HRS AT 350-400F WITHIN 4 HRS OF CHROME PLATE *C/P MOVE					001 MNPRC 002 02 003 BK01		

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21020N	
		B	D		

## 21020N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 5 OF 5 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		ANTI-ROTATION BOLT							
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		DATE IN: _____ TIME IN: _____							
		DATE OUT: _____ TIME OUT: _____							
8	120	FINISH GRIND BOLT SHANK. FINISHED DIA OD 1.622/1.623. MAINTAIN EXISTING RADIUS 63 RMS *C/P MOVE					001 MNPRB 002 01 003 GE00		
		RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS							
26B	130	BAKE 4 HOUR AT 350 TO 400F *C/P MOVE DATE IN: _____ TIME IN: _____					001 MNPRC 002 02 003 BK01		
		DATE OUT: _____ TIME OUT: _____							
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****				H	001 MNPNA 002 06 003 KLD4		
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****				M	001 MNPNA 002 06 003 ZS01		
26	145	VAPOR DECREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
		[REDACTED] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21020N			
		B		D					



## 21020N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 6 OF 6 PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN ANTI-ROTATION BOLT	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
26	155	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL04	
26	160	CAD PLATE TYPE II CLASS II TIME OUT _____ DATE OUT _____ *C/P MOVE		001 MNPRC 002 03 003 CAD1	
26B	170	BAKE 24 HRS AT 350 - 400F WITHIN 4 HRS OF CAD PLATE *C/P MOVE DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____		001 MNPRC 002 02 003 BK01	
26	180	(IRIDITE) CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 1R01	
		*C/P MOVE ***** N O T E ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****		001 MNPRC 002 06 003 BL04	
26	191	IVD PLATE OPTION (INITIATED BY PLATING) IF CHROME REWORK WAS ACCOMPLISHED, OPERATION 170 MUST BE DONE PRIOR TO IVD OPTION. *C/P MOVE		001 MNPRC 002 03 003 IVD1	
26	192	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		001 MNPRC 002 03 003 TAD1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21020N
		B	D	

## 21020N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 7 OF 7 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		ANTI-ROTATION BOLT							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. "Q"	
	195	PAINT *C/P MOVE						001 MNP0P 002 09 003 WB03	
	200	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958						001 MNP0P 002 01 003 MU06	
	210	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*						001 MNP0P 002 01 003 MU06	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21020N			
		B		D					

## 21024N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 1 OF 1 PAGES

2 JOB ORDER NO	3. QUANTITY	4 PRODUCTION SEC/RCC MNP GP	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8. TECH DATA 4S-1-182 451-92-2 AND SUPPLEMENTS	9. ITEM SERIAL NO
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10 MODEL-DESIGN-SERIES C5A MAIN	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN TRUNNION CROSS BOLT
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
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P/N 4613347-101A	NSN 5306004541547	C/N 17575A 17576A 17577A 17578A			7 8
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		***** UNIT COST: \$238.00 ***** GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3			
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		IAD PLATE IAW MIL-C-83400A FMPI IAW MIL-STD-1949 P/O N01561			
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		ALODINE IAW MIL-C-5541			
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		STRIP CHROME IAW MIL-STD-871			
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		GRIND IAW MIL-STD-868			
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		TEMPER ETCH IAW MIL-STD-647			
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		SHOT PEEN IAW MIL-S-13165			
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		CAD PLATE IAW MIL-STD-871			
--	--	---------------------------	--	--	--

		CHROME PLATE IAW MIL-STD-1501			
--	--	-------------------------------	--	--	--

		TYPE II CLASS III P/O N61891			
--	--	------------------------------	--	--	--

		FPI IAW MIL-STD-6866			
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		BAKE IAW 4S-1-182			
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		MAOI 74-12			
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		***** 300 M 280/300 KSI *****			
--	--	-------------------------------	--	--	--

		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN			
--	--	--	--	--	--

		THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLO FORM 959. THE			
--	--	--	--	--	--

		T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
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		* COMPONENTS WILL BE THOROUGHLY			
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21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
DISPATCH	A	21024N

FUNCTIONAL CODE	B	D
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## 21024N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN TRUNNION CROSS BOLT						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REDD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	4613247-101A							
	005	DISASSEMBLE *C/P MOVE					001 MNPBP		
	*REDD*						002 01		
							003 SD03		
		CHEM CLEAN *C/P MOVE					001 MNPBW		
	*REDD*						002 03		
							003 SL01		
		BLAST CLEAN ONLY *C/P MOVE					001 MNPBW		
	*REDD*						002 03		
							003 BL07		
		BAKE 4 HRS AT 350-400F					001 MNPBW		
	*REDD*	DATE IN _____ TIME IN _____					002 03		
							003 BK03		
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21024N			
		B		D					

251

## 21024N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 3 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN		TRUNNION CROSS BOLT					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		*C/P MOVE				M	001 MNPNA		
	*REDD*						002 05		
							003 MS03		
		E AND I INSPECTION					001 MNPBW		
	*REDD*	BOLT SHANK O.D. 2.249/2.250					002 04		
		WEAR 2.249					003 EI01		
26	035	VAPOR DEGREASE					001 MNPFC		
		*C/P MOVE					002 03		
							003 DG01		
26	040	STRIP OAD					001 MNPFC		
		*C/P MOVE					002 02		
							003 CS01		
26	045	STRIP RUST					001 MNPFC		
		*C/P MOVE					002 02		
							003 CS02		
26	050	STRIP CHROME					001 MNPFC		
		*C/P MOVE					002 02		
							003 SC02		
69	055	RECENTER IF NECESSARY					001 MNPRA		
		*C/P MOVE					002 02		
							003 LE03		
8	060	FIRST GRIND BOLT SHANK					001 MNPFP		
		MINIMUM GRIND SIZE O.D. 2.2350					002 01		
		63 RMS					003 GE00		
		*C/P MOVE							
		TIME OUT _____ DATE OUT _____				M	001 MNPNA		
		*C/P MOVE					002 06		
							003 TE03		
***** NOTE *****									
IF LAST NDI OPERATION IS COMPLETED*									
HERE, TAKE PRODUCTION COUNT *									
(CONTINUED)									

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21024N	
		B	D		

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		TRUNNION CROSS BOLT							
15 DISPATCH STATION	16 PERP RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		*****							
26B	080	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH DATE IN: _____ TIME IN: _____					001 MNPRC 002 02 003 BK01		
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT ***** *C/P MOVE					001 MNPRC 002 06 003 BLO4		
26	095	VAPOR DECREASE *C/P MOVE					001 MNPRC 002 03 003 B601		
26	100	SHOT PEEN BOLT INTENSITY .008/.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	103	PREPARE BOLT SHANK FOR CHROME PLATE, MASK/FIXTURE/ETC. MECHANIC SIGN OFF REQUIRED----->					001 MNPRC 002 02 003 BE01		
26	107	PREPARE FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BLO4		
26	110	CHROME PLATE BOLT SHANK SUFFICIENT TO GRIND BACK TO 2.249/2.250 (CONTINUED)					001 MNPRC 002 02 003 CP01 004 C0010		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21024N
		B	D	

## 21024N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 5 OF 5 PAGES

2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN TRUNNION CROSS BOLT						
15 DISPATCH STATION	16 PERP RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		DATE OUT: _____ TIME OUT: _____ MECHANIC SIGN OFF REQUIRED: _____ *C/P MOVE							
26B	120	BAKE 4 HOURS AT 350 TO 400F WITHIN 4 HRS OF CHROME DATE IN: _____ TIME IN: _____					001 MNPRC 002 02 003 BK01		
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE							
8	130	FINISH GRIND BOLT SHANK. FINISH DIAMETER O.D. 2.249/2.250. 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED					001 MNPRE 002 01 003 0500		
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS. _____ *C/P MOVE							
26B	140	BAKE 4 HOURS AT 350 TO 400F DATE IN: _____ TIME IN: _____					001 MNPRC 002 02 003 BK01		
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE							
		*C/P MOVE					001 MNPRE 002 06 003 MLO4		
		***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *							
		*****							
26	155	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21024N			
		B		D					

254

## 21024N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 6 OF 6 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN TRUNNION CROSS BOLT	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****	M	001 MNPNA 002 06 003 ZS01	
26	165	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		001 MNPRC 002 01 003 BL04	
26	170	CAD PLATE TYPE II CLASS II TIME OUT: DATE OUT: *C/P MOVE		001 MNPRC 002 03 003 C401	
26	180	BAKE 25 HOURS AT 350 TO 400F WITHIN 4 HRS OF CAD PLATE DATE IN: TIME IN:		001 MNPRC 002 02 003 BR01	
		DATE OUT: TIME OUT: *C/P MOVE			
26	190	(IRIDITE) CHROMATE CONVERSION COATING *C/P MOVE		001 MNPRC 002 02 003 IR01	
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****	M	001 MNPNA 002 06 003 ML04	
26	201	IVD PLATE (INITIATED BY PLATING) *NOTE* IF CHROME REWORK WAS ACCOMPLISHED, OPERATION 180 MUST (CONTINUED)		001 MNPRC 002 03 003 IV01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21024N
		B	D	



## 21024N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 7 OF 7 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		TRUNNION CROSS BOLT							
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		BE DONE PRIOR TO IVD OPTION. *C/P MOVE							
26	202	ALLODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE						001 MNPFC 002 03 003 TA01	
	205 *REQD*	DEGREASE & PRE-PAINT *C/P MOVE						001 MNPGP 002 09 003 PP01	
	206 *REQD*	PAINT *C/P MOVE						001 MNPGP 002 09 003 W803	
	210 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 258						001 MNPGP 002 01 003 HU06	
	220 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE						001 MNPGP 002 01 003 HU06	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21024N			
		B		D					

## 21025N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 1 OF 1 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC MNPGR		5 DATE SCHED		6 DATE COMPLETED			
7 PART NUMBER				8 TECH DATA 4S-1-182 4S-1-92-2 AND SUPPLEMENTS				9 ITEM SERIAL NO <b>17575A</b>			
10 MODEL-DESIGN-SERIES CSA MAIN				11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER				14 NOUN SIDE BRACE APEX BOLT							
15. DISPATCH STATION		16. PERF RCC/OP NO		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P" "Q"		
P/N 4G13537-101A		1620001164433		NSN C/N 17575A 17576A 17577A 17578A					<b>6</b> <b>7</b> <b>8</b>		
				***COST: \$250.29*** GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3							
				IWB PLATE IAW MIL-C-88488A							
				FMPI IAW MIL-STD-1949 P/O N01561							
				ALODINE IAW MIL-C-5541							
				STRIP CHROME IAW MIL-STD-871							
				GRIND IAW MIL-STD-866							
				TEMPER ETCH IAW MIL-STD-867							
				SHOT PEEN IAW MIL-S-13165							
				CAD PLATE IAW MIL-STD-879							
				CHROME PLATE IAW MIL-STD-1501 TP II CL III P/O N61891							
				FPI IAW MIL-STD-6866							
				BAKE IAW 4S-1-182 MANOI 74-12							
				MAT'L: 300M STEEL (280/300 KSI)							
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. * COMPONENTS WILL BE THOROUGHLY (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE								23. DOCUMENT/SN	
DISPATCH		FUNCTIONAL CODE		A		C				21025N	
				B		D					

257

## 21025N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SIDE BRACE APEX BOLT						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	4613537-101A							
	005	DISASSEMBLE *C/P MOVE					001 MNPGW		
	*REQD*						002 01		
							003 SD03		
		CHEM CLEAN *C/P MOVE					001 MNPGW		
	*REQD*						002 03		
							003 BL01		
		BLAST CLEAN ONLY *C/P MOVE					001 MNPGW		
	*REQD*						002 03		
							003 BL01		
		BAKE 4 HRS AT 350-400F					001 MNPGW		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
							003 BK03		
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21025N			
		B		D					

250

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## 21025N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 3 OF 4 PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
---------------	-------------	-------------------

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
------------------------	-----------------	-------------

13 SERIAL NUMBER	14 NOUN
	SIDE BRACE APEX BOLT

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
---------------------	-------------------	----------------------------	-------------	--------	--------

		*C/P MOVE	M	001 MNPNA	
	*REQD*			002 05	
				003 HS03	

		E AND I INSPECTION		001 MNPON	
	*REQD*	BOLT SIZE O.D. 2.9985/2.999		002 04	
		WEAR 2.998		003 EI01	

		*NOTE: A MINIMUM OF 2 FMPI			
		OPERATIONS MUST BE ACCOMPLISHED.			
		*C/P MOVE			

26	025	VAPOR DECREASE	*C/P MOVE	001 MNPRC	
				002 03	
				003 DD01	

26	030	STRIP OAD	*C/P MOVE	001 MNPRC	
				002 02	
				003 CS01	

26	035	STRIP RUST	*C/P MOVE	001 MNPRC	
				002 02	
				003 CS02	

26	040	STRIP CHROME FROM OUTER DIAMETER		001 MNPRC	
		*C/P MOVE		002 02	
				003 SC02	

69	045	RECENTER IF NECESSARY	*C/P MOVE	001 MNPRA	
				002 02	
				003 LE03	

8	050	FIRST GRIND BOLT SHANK		001 MNPRA	
		MIN DIA O.D. 2.9835		002 01	
		MAINTAIN EXISTING RADIUS 63 RMS		003 GE00	

		*C/P MOVE		001 MNPNA	
		TIME OUT	DATE OUT	002 06	
		***** NOTE *****		003 TE03	

(CONTINUED)

21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
DISPATCH	A	21025N
FUNCTIONAL CODE	C	
	B	
	D	

259

## 21025N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 4 OF 4 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
---------------	-------------	------------------

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
------------------------	-----------------	-------------

13 SERIAL NUMBER	14 NOUN
	SIDE BRACE APEX BOLT

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
---------------------	-------------------	----------------------------	-------------	--------	--------

		IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****			
--	--	---	--	--	--

26B	070	BAKE 4 HOURS AT 350 TO 400F WITHIN 8 HRS OF ETCH		001 MNPFC 002 02 003 BK01	
-----	-----	---	--	---------------------------------	--

		DATE IN: _____ TIME IN: _____ DATE OUT: _____ TIME OUT: _____ *C/P MOVE			
--	--	---	--	--	--

		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****	M	001 MNPFA 002 06 003 MLD4	
--	--	--	---	---------------------------------	--

--	--	--	--	--	--

26	085	VAPOR DECREASE *C/P MOVE		001 MNPFC 002 03 003 DB01	
----	-----	--------------------------	--	---------------------------------	--

26	090	SHOTPEEN INTENSITY OF .008/.12 A2 *C/P MOVE		001 MNPFC 002 01 003 SP02	
----	-----	---	--	---------------------------------	--

26	093	PREPARE FOR CHROME PLATE, MASK/FIXTURE/ETC MECHANIC SIGN OFF REQUIRED----- *C/P MOVE		001 MNPFC 002 02 003 BE01	
----	-----	---	--	---------------------------------	--

26	097	PREPARE FOR CHROME PLATE, GRIT BLAST *C/P MOVE		001 MNPFC 002 01 003 BL04	
----	-----	---	--	---------------------------------	--

26	100	CHROME PLATE SUFFICIENT TO GRIND BACK TO 2.9985/2.999		001 MNPFC 002 02 003 CP01 008 C0010	
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(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21025N
		B	D	

260

## 21025N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 5 OF 5 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SIDE BRACE APEX BOLT						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		DATE OUT _____ TIME OUT _____ MECHANIC SIGN OFF REQUIRED _____ *C/P MOVE							
26B 1	110	BAKE 4 HOURS AT 350 TO 400F WITHIN 4 HRS OF CHROME  DATE IN: _____ TIME IN: _____  DATE OUT: _____ TIME OUT: _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
8	120	FINISH GRIND BOLT SHANK. FINISH DIAMETER O.D. 2.9985/2.999 63 RMS RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS _____ *C/P MOVE					001 MNPRC 002 01 003 BE00		
26B 2	130	BAKE 4 HOURS AT 350 TO 400F  DATE IN: _____ TIME IN: _____  DATE OUT: _____ TIME OUT: _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
		[REDACTED] *C/P MOVE					001 MNPRC 002 06 003 ML04		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****				M			
26 3	145	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21025N			
		B		D					

## 21025N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 6 OF 6 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SIDE BRACE APEX BOLT						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT ***** *****				M	001 MNPNA 002 06 003 ZS01		
26	155	PRIOR TO CAD/IVD, GRIT BLAST ALL AREASE TO BE CAD/IVD PLATED *C/P MOVE					001 MNPRC 002 01 003 EL04		
26	160	CAD PLATE TYPE II CLASS II TIME OUT: _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CAD1		
26B	170	BAKE 23 HOURS AT 350 TO 400F WITHIN 4 HRS OF CAD DATE IN: _____ TIME IN: _____					001 MNPRC 002 02 003 BK01		
		DATE OUT: _____ TIME OUT: _____ *C/P MOVE							
26	180	(IRIDITE) CHROMATE CONVERSION COATING *C/P MOVE					001 MNPRC 002 02 003 IR01		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT ***** *****				M	001 MNPNA 002 06 003 ML04		
26	191	IVD PLATE (INITIATED BY PLATING) *NOTE* IF CHROME REWORK WAS ACCOMPLISHED, OPERATION 170 MUST (CONTINUED)					001 MNPRC 002 03 003 IV01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21025N			
		B		D					

## 21025N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 7 OF 7 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER		12 OPTIONAL			
13 SERIAL NUMBER				14 NOUN					
				SIDE BRACE APEX BOLT					
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		BE DONE PRIOR TO IVD OPTION. *C/P MOVE							
26	192	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE					001 MNPRC 002 03 003 TA01		
	193 *REQD*	DEGREASE & PRE-PAINT *C/P MOVE					001 MNPGP 002 09 003 PP01		
	195 *REQD*	PAINT IAW 4S-1-182 & 4S1-93-3 *C/P MOVE					001 MNPGP 002 09 003 WB03		
	200 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNPGP 002 01 003 MU06		
	210 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNPGP 002 01 003 MU06		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21025N			
		B		D					



## 21026N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 1 OF 1 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
		MNP6P		

7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
	4S-1-182	

10 MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL SUPPLEMENTS
CSA MAIN		

13 SERIAL NUMBER	14 NOUN
	COLLAR LOCK COLLAR

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19
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P/N	NSN	C/N		
4611447-101A	1620001157389	17575A		
		17576A		
		17577A		
		17578A		

\*\*\*\*\*COST: \$3622.35\*\*\*\*\*

GOVERNING DIRECTIVES: AFLOR 66-51  
MANOI 66-3

ALOBINE IAW MIL C 5541

FMPI IAW MIL-STD-1949

F/O NO1561

STRIP CAD IAW MIL-STD-871

CAD PLATE IAW MIL-STD-870

IVD PLATE IAW MIL-C-80468A

TEMPER ETCH IAW MIL-STD-867

BLAST IAW MIL-STD-150A

PAKE IAW 4S-1-182

MANOI 74-12

\*\*\*MATERIAL: 300M STEEL (280/300 KSI)\*\*\*

ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY

PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 3 OF THIS AFLC FORM 258. THE

APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.

\* COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21026N
		B	D	

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO	
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL					
13. SERIAL NUMBER		14. NOUN							
		DOLLAR LOCK DOLLAR							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		<p>WARNING</p> <p>MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES &amp; CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.</p> <p>*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.</p>							
	001	4011447-101A							
	005 *REQD*	DISASSEMBLE *C/P MOVE					001 MNPDP 002 01 003 SD03		
		CHEM CLEAN *C/P MOVE					001 MNPBW 002 03 003 SL01		
		GLASS BEAD BLAST TO REMOVE CORROSION *C/P MOVE					001 MNPBW 002 03 003 BL07		
		BAKE 4 HRS AT 350-400F					001 MNPBW 002 03 003 BK03		
	*REQD*	DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21026N			
		B		D					

## 21026N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 3 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES				11 STOCK NUMBER				12 OPTIONAL	
13 SERIAL NUMBER				14 NOUN COLLAR LOCK COLLAR					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
		*C/P MOVE				M	001 MNNA		
	*REQD*						002 05		
							003 MS03		
		E AND E INSPECTION					001 MNPBW		
	*REQD*						002 04		
		ATTACHING LUG BUSHINGS I.D. .249/.251 WEAR .2525 FACE TO FACE INSIDE .344/.348					003 EI01		
		ATTACHING LUGS BASE METAL, MAX REWORK I.D. .500 *C/P MOVE							
26	043	VAPOR DEGREASE *C/P MOVE					001 MNPBC		
							002 03		
							003 BG01		
26	045	STRIP CAD *C/P MOVE					001 MNPBC		
							002 02		
							003 CS01		
26	047	STRIP RUST *C/P MOVE					001 MNPBC		
							002 02		
							003 CS02		
69	050	NICK AND BURR *C/P MOVE					001 MNPRA		
							002 02		
							003 BE01		
69	052	ATTACHING LUG HOLE (LEFT SIDE) REPAIR. LINE REAM TO CLEANUP, NOT TO EXCEED ID .500 MAINTAIN EXISTING HOLE LOCATIONS. *C/P MOVE					001 MNPRA		
							002 02		
							003 BE01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21026N			
		B		D					

## 21026N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 4 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN							
		COLLAR LOCK COLLAR							
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
69	054	ATTACHING LUG HOLE (RIGHT SIDE) REPAIR. LINE REAM TO CLEANUP, NOT TO EXCEED ID .500 MAINTAIN EXISTING HOLE LOCATIONS. *C/P MOVE					001 MNPRA 002 02 003 BE01		
		DATE OUT TIME OUT *C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *							
265	057	BAKE 4HRS AT 350-400F WITHIN 6HRS OF ETCH DATE IN TIME IN					001 MNPRA 002 02 003 BK01		
		DATE OUT TIME OUT *C/P MOVE							
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *							
26	060	VAPOR DECREASE *C/P MOVE					001 MNPRA 002 03 003 BG01		
26	070	SHOT PEEN REWORKED AREA'S INTENSITY OF .005/.010 A2 SHOT SIZE 110 *C/P MOVE					001 MNPRA 002 01 003 SP02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21026N			
		B		D					

## 21026N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 5 OF 5 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN COLLAR LOCK COLLAR						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 "P"	20 "Q"	
26	080	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE					001 MNPRC 002 01 003 BLO2		
26	090	CAD PLATE TYPE II CLASS II TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CAD1		
26B	100	BAKE 24 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	110	(IRIDITE) CHROMATE CONVERSION COATING *C/P MOVE					001 MNPRC 002 02 003 IR01		
		[REDACTED] *C/P MOVE ***** N O T E ***** IF LAST ADD OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****				M	001 MNPRC 002 05 003 MLO1		
26	121	IVD PLATE (INITIATED BY PLATING) *C/P MOVE					001 MNPRC 002 03 003 IVO1		
26	122	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE					001 MNPRC 002 03 003 TA01		
69	128	MACHINE ATTACHING LUG (LEFT SIDE) BUSHING P/N 4613609-103A *C/P MOVE					001 MNPRC 002 02 003 LE02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21026N			
		B		D		268			

## 21026N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 6 OF 6 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA			9 ITEM SERIAL NO

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN COLLAR LOCK COLLAR	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
69	130	ATTACHING LUG (LEFT SIDE) BUSHING INSTALLATION. PRESS FIT .0004/ .002. BRUSH CAD AND INSTALL WITH MIL-C-16173D, GRADE 2, AND 2 FINISH BUSHING DIA ID .249/ .251 FACE TO FACE INSIDE .344/ .348 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 02 003 BE01	
69	138	MACHINE ATTACHING LUG (RIGHT SIDE) BUSHING P/N 4013509-103A *C/P MOVE		001 MNPRA 002 02 003 LE02	
69	140	ATTACHING LUG (RIGHT SIDE) BUSHING INSTALLATION. PRESS FIT .0004/ .0012 BRUSH CAD AND INSTALL WITH MIL-C-16173D, GRADE 2, AND 2 FINISH BUSHING DIA ID .249/ .251 FACE TO FACE INSIDE .344/ .348 RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE		001 MNPRA 002 02 003 LE01	
	145	PAINT *C/P MOVE *REQD*		001 MNPGR 002 09 003 WB03	
	150	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQD*		001 MNPGR 002 01 003 MU06	
	160	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*		001 MNPGR 002 01 003 MU06	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21026N
		B	D	

# WORK CONTROL DOCUMENT (MDS)

DATE

2. JOB ORDER NO 21030N	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED 89035	6. DATE COMPLETED 1
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7. PART NUMBER	8. TECH DATA MNP GP	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER 4S-1-182 4S1-93-3 AND SUPPLEMENTS	12. OPTIONAL
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13. SERIAL NUMBER USA MLG	14. NOUN
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. LOCK RINGWORK BY MACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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P/N	NSN	C/N
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4612636-101A	1620001157427	17575A 17577A 17578A
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21. FINAL DESTINATION *REQ DISPATCH	22. (MANY INFORMATION REQUIRED FOR SIGNATURE/DATE FUNCTIONAL CODE A 16 IS EQUIVALENT TO DELTA (CONTINUED)	23. DOCUMENT/BN
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		21020N 270
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# WORK CONTROL DOCUMENT

2. JOB ORDER NO 21030N	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED 89035	6. DATE COMPLETED 2 2
7. PART NUMBER	8. TECH DATA			9. ITEM SERIAL NO.
10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL		
13. SERIAL NUMBER	14. NOUN			
15. DISPATCH STATION	16. PERF RCC/OP NO	17. <b>ASSY MLG</b> LOCK RING WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"
				20. "Q"
		STAMP.		
	001	4612636-101A		
	005A	Disassembly		
49		<del>REWORK TO BE ACCOMPLISHED</del>		001 MNPRA
		NEW SERVICEABLE	REWORKED 958	002 02
			NO REWORK	003 BE01
		LOCK COLLAR GUIDE 21031N		
		COLLAR LOCK RING 21032N		
		LOCK RING NUT 21049N		
49		<del>REWORK TO BE ACCOMPLISHED</del>		001 MNPRA
		PARTS		002 02
		*C/P MOVE		003 BE01
49	030	ASSEMBLE COMPONENT PARTS REQUIRED		001 MNPRA
		OF LOCK RING ASSEY PER T.O. 431-72-3		002 02
		*****N O T E*****		003 BE01
		INSURE TORQUE VALUE OF 800 +/- 100		
		INCH POUNDS HAS BEEN MET. GREASE		
		PARTS PRIOR TO ASSEMBLY USING		
		MIL-G-81322 OR EQUAL. *C/P MOVE		
	040	FINAL ACCEPTANCE OF WORK CONTROL		001 MNPGR
	*REQD*	DOCUMENT FOR COMPLETENESS & ACCURACY		002 01
		OF ALL PRECEDING OPERATIONS THIS 958		003 MU06
	050	FINAL PRODUCT VISUAL INSPECTION		001 MNPGR
21. FINAL DESTINATION	*C/P	MOVE	COORDINATION/INITIATING RCC SIGNATURE/DATE	
DISPATCH + REF	FUNCTIONAL CODE	A	C	002 DOCUMENT
		B	D	003 MU06
				21030N



PAGE 1 OF 1 PAGES					
2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED	
21031N			89035	1	
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.	
		MNP0P			
10. MODEL DESIGN SERIES		11. STOCK NUMBER	12. OPTIONAL		
		4S-1-182	4S1-93-3 AND SUPPLEMENTS		
13. SERIAL NUMBER		14. NOUN		17575A	
C5A MLG					
15. DISPATCH STATION	16. PERF RCC/OP NO	17. LOCK DOWN WORK TO BE ACCOMPLISHED		18. MECHANIC	20.
P/N		NSN	C/N		6
4613569-101A		1620010751661	17575A 17576A 17577A 17578A		7
		***** UNIT COST: \$960.00*****			8
		GOVERNING DIRECTIVES: AFMOP 66-51 MANOI 66-3 FPI 1AW MIL-STD-883A			
		*****NAT'L BERYLIUM COPPER*****			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN BASIC TECHNICAL ORDERS (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P NOTED) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO			
21. FINAL DESTINATION		22. PRECISE LOCATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN	
DISPATCH	FUNCTIONAL CODE	A (CONTINUED)			
		B			
		C			
		D			
				21031N 272	

# WORK CONTROL DOCUMENT (MEDS)

DATE

PAGE 01 OF 01 PAGES

2. JOB ORDER NO 21031N		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED 89035		6. DATE COMPLETED 2	
7. NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. LOCK COLL WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	4613569-101A							
0405	005	DISASSEMBLE *C/P MOVE					001 MNPBP		
	*REQD*						002 01		
	007	CHECK CLEAN *C/P MOVE					003 5D23		
	*REQD*						001 46135		
041	015	FPI *C/P MOVE					002 02		
	*REQD*						003 MU24		
042	020	E&I INSPECTION					001 MNPNA		
	*REQD*	VISUAL INSPECT TAW 481-93-2					002 05		
	*REQD*	*****NAMES***** GUIDE IS BERYLLIUM-CL -LX					003 2Y05		
		*C/P MOVE					001 MNPBP		
		REWORK DAMAGED THREADS T.O. 481-93-2 125RMS					002 02		
		SURFACE .430 MINIMUM					003 BE01		
		C/P *MOVE					001 MNPRA		
043	040	FPI					002 02		
		C/P *MOVE					003 LE06		
044		FPI					001 MNPNA		
045		FPI					002 05		
046		FPI					003 2Y05		
047		FPI							
048		FPI							
049		FPI							
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098		FPI							
099		FPI							
100		FPI							

## 1. DATE

**PAGE\_\_OF\_\_PAGES**

21031N

274

# WORK CONTROL DOCUMENT (MEDS)

DATE

PAGE 07 PAGES

2. JOB ORDER NO 21032N	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED 89035	6. DATE COMPLETED 1
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7. PART NUMBER	8. TECH DATA MNP6P	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER 4S-1-182 4S1-21-3 AND SUPPLEMENTS	12. OPTIONAL <b>17575A</b> <b>6</b>
13. SERIAL NUMBER CDA HLB	14. NOUN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. COLLAR LOW WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "M"
P/N		NSN C/N			

4612412-101A	1620001357841	17575A 17576A 17577A 17578A			
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		***** UNIT COST: \$992.16 *****			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FMPI IAW MIL-STD-1945 P/O N61641			

		STRIP CHROME IAW MIL-STD-871 GRIND IAW MIL-STD-862 TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13145			
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		CHROME PLATE IAW MIL-STD-1501 TP II CL III P/O N61891 DRY FILM LUBE IAW MIL-L-46010 PHOSPHATE TREATMENT IAW DGD-P-16232 P/O N73061			
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		FPI IAW MIL-STD-6864 BAKE IAW 4S-1-182 MAOI 74-12			
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		*****MAT'L 300M (280/300 KSI)*****			
--	--	------------------------------------	--	--	--

		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.)			
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		AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
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21. FINAL DESTINATION*COMPONENTS COORDINATION/REMOVAL SIGNATURE/DATE	22. DOCUMENT/SN
DISPATCH FUNCTIONAL CODE CLEANED & PROTECTED (C/P) (MOVE) FOR (CONTINUED)	

	21032N
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U.S. GOVERNMENT PRINTING OFFICE: 1989-448-18

WORK CONTROL DOCUMENT (NEW)						DATE			
2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
21032N						89035		2	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL					
13. SERIAL NUMBER		14. NOUN							
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK ITEMS ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		COLLAR LOWERING							
		MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING							
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF							
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	4613412-101A							
2405	005	DISASSEMBLE *C/P MOVE					001 MNPBW		
	*REQD*						002 01		
							003 SD03		
240	007	CHEN CLEAN *C/P MOVE					001 MNPBW		
	*REQD*						002 03		
							003 BL01		
34B	009	BLAST CLEAN *C/P MOVE					001 MNPBW		
	*REQD*						002 03		
							003 BL01		
34B	011	BAKE 4 HRS AT 350-400F					001 MNPBW		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
		DATE OUT _____ TIME OUT _____					003 BK03		
21. FINAL DESTINATION *C/P		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN					
DISPATCH	FUNCTIONAL CODE	A	C						
				21032N 220					

# WORK CONTROL DOCUMENT (MEDICAL)

DATE

PAGE 2 OF 2

2. JOB ORDER NO 21032N		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED 89035		6. DATE COMPLETED 3	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
34M	013	COLLAR LOW WORN TO BE ACCOMPLISHED *C/P MOVE							
	*REQD*					M	001 MNFNA		
							002 05		
							003 MS03		
34E	018	E & I INSPECTION					001 MNFGW		
	*REQD*	CHROMED DIA 11.801/11.799 WEAR 11.797 CHECK ROTATIONAL FREE PLAY OF SPLINE MAX 0 TO 15 DEGREES					002 04		
							003 EIC1		
34E	019	VISUAL INSPECT SURFACE DAMAGE *C/P MOVE NICK & BURR: IF SPLINES ARE					001 MNFGW		
		REWORKED RECHECK ROTATIONAL FREE PLAY *C/P MOVE					002 04		
							003 EIC1		
24	050	VAPOR DEGREASE *C/P MOVE					001 MNPRC		
							002 03		
							003 DGO1		
24	060	STRIP CHROME FROM MAJOR O.D. *C/P MOVE					001 MNPRC		
							002 02		
							003 SC02		
24	065	STRIP CHROME FROM SHOULDER AREA *C/P MOVE					001 MNPRC		
							002 02		
							003 SC02		
24	070	GRIND CORROSION ON FACE OF TEETH-MIN. OVERALL DIM. OF 1.84 WITH 63RMS FIN. *C/P MOVE					001 MNPRB		
							002 03		
							003 GR01		
		GRIND OF TEETH 0.020-					001 MNPRB		
		0.040 X 45 *UR					002 03		
		*C/P MOVE					003 BE01		
		SENT TO DIA					001 MNPRC		
21. FINAL DESTINATION		11.801		11.799		COORDINATING INITIALS AND SIGNATURE		DATE	
DISPATCH	FUNCTIONAL CODE	10 EXCEED MIN. DIM. OF .875 AS		(CONTINUED)				003 BE05	
								005 X874522	
								21032N 227	

2. JOB ORDER NO 21032N		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED 89035		6. DATE COMPLETED 4	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. COLLAR LOWER TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		MEASURED FROM FACE TO SHOULDER. DIA A & B PERPENDICULAR WITHIN .001 INCH PER INCH *C/P MOVE							
		MIN. U.D. 11.783 DIA A & B PERPENDICULAR WITHIN .001 INCH PER INCH *C/P MOVE						001 MNFRB	
26	100	TEMPER ETCH REWORKED AREAS OF TEETH						002 03	
		TIME OUT _____ DATE OUT _____ *C/P MOVE						003 GE05	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****						005 X8745172	
		TEMPER ETCH MAJ. DIA.						001 MNFNA	
		TIME OUT _____ DATE OUT _____ *C/P MOVE						002 06	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****						003 TE03	
26	110	TEMPER ETCH MAJ. DIA.						001 MNFNA	
		TIME OUT _____ DATE OUT _____ *C/P MOVE						002 06	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****						003 TE03	
26	120	TEMPER ETCH SHOULDER						001 MNFNA	
		TIME OUT _____ DATE OUT _____ *C/P MOVE						002 06	
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****						003 TE03	
26B	130	BAKE 4 HRS AT 350 TO 400 F WITHIN 8- HRS OF ETCH						001 MNPRC	
		DATE IN: _____ TIME IN: _____						002 02	
								003 BK03	
21. FINAL DESTINATION DATE		22. COORDINATION		23. SIGNATURE/DATE		24. DOCUMENT/SA			
DISPATCH	FUNCTION/MP CODE	MOVE		C					
		B		D					
						21032N 228			

## WORK CONTROL DOCUMENT (MEDS)

DATE

PAGE 1 OF 2 PAGES

2. JOB ORDER NO 21032N		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED 89035		6. DATE COMPLETED 5	
7. PART NUMBER			8. TECH DATA			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN						
15. DISPATCH STATION	16. PERP RCC/OP NO	17. COLLAR LOW WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26	140	FMPI *C/P MOVE					001 MNFNA		
		***** NOTE ***** IF LAST NDL OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****					002 06 003 MLC4		
26	145	VAPOR DECREASE *C/P MOVE					001 MNPRC 002 03 003 BGC1		
26	145	GRIT BLAST SPLINE TO REMOVE CORROSION/RIDGES NOT EXCEEDING .010 DEPTH. *C/P MOVE					001 MNPRC 002 01 003 EL02		
26	150	SHOT PEEN GROUND FACES OF TEETH .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	160	SHOT PEEN MAJ. DIA. .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	170	SHOT PEEN SHOULDER AREAS OF MAJ. DIA .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	175	SHOT PEEN SPLINES AFTER GRIT BLAST .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	176	PREPARE MAJOR DIA FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BLC4		
26	178	PREPARE MAJOR DIA FOR CHROME					001 MNPRC		
21. FINAL DESTINATION		22. MASK COATING		23. MASKING RCC SIGNATURE/DATE		24. DOCUMENT NO.			
DISPATCH	FUNCTIONAL CODE	MECHANIC SIGN OFF REQUIRED				002 BE01 003 XB120918			
						21032N 229			

U.S. GOVERNMENT PRINTING OFFICE: 1989-448-18





# WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE 1 OF 1

2. JOB ORDER NO 21032N		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED 89035		6. DATE COMPLETED 7	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		COLLAR LOWER TO BE ACCOMPLISHED							
		HERE, TAKE PRODUCTION COUNT *							
		*****							
24	225	VAPOR DECREASE *C/P MOVE						001 MNPRC	
								002 03	
								003 DG01	
24A	230	FPI *C/P MOVE						001 MNFNA	
		***** NOTE *****				M		002 06	
		IF LAST NDI OPERATION IS COMPLETED*						003 Z501	
		HERE, TAKE PRODUCTION COUNT *							
		*****							
24	270	PREPARE FOR PHOSPHATE, GRIT BLAST						001 MNPRC	
		*C/P MOVE						002 01	
								003 BL02	
24	280	PHOSPHATE TREATMENT FINISH TYPE M						001 MNPRC	
		*C/P MOVE						002 03	
								003 PH01	
24B	290	BAKE 3 HRS AT 210-250						001 MNPRC	
		DATE IN _____ TIME IN _____						002 02	
								003 BK02	
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
26	300	DRY FILM LUBE ON SHOULDER ADJACENT						001 MNPRC	
		TO 11.801 DIA. MAX THICKNESS .001						002 03	
		*C/P MOVE						003 EL01	
26B	310	BAKE 1 HR AT 400 DEGREES F						001 MNPRC	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENTATION			
DISPATCH	FUNCTIONAL CODE	IN _____ TIME IN _____				002 00			
		(CONTINUED)				003 BK02			
						21032N 241			

## PAGE 01 OF 1 PAGE

21082N

U.S. GOVERNMENT PRINTING OFFICE: 1969-549-109

2. JOB ORDER NO 21033N	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED 89035	6. DATE COMPLETED 1
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7. PART NUMBER	8. TECH DATA MNP GP	9. ITEM SERIAL NO.
----------------	------------------------	--------------------

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER 48-1-182/481-93-3 & SUPPLEMENTS	12. OPTIONAL
13. SERIAL NUMBER CSA MLG	14. NOUN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. UPPER PLATEWORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "S"
P/N		NSN C/N			
4012423-101A		1620004182976 17575A 17576A 17577A 17578A			
		****COST: \$195.34****			
		GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3			
		SHOTPEEN I A W MIL-S-13165 F.P.I. I A W MIL-SID-6866			
		ANODIZE I A W MIL-A-8625 ALODINE I A W MIL-C-5541 STRIP I A W MIL-STD-871			
		**MATERIAL 7025-723 ALUMINUM**			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED THEREIN. ALL APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		*****"W A R N I N G"*****			
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO			

21. FINAL DESTINATION PERSONNEL. COORDINATION INITIATED BY DATE	22. DOCUMENT/SS
DISPATCH FUNCTIONAL RECAUTIONS MUST BE EMPLOYED TO (CONTINUED)	
	21033A 283

U.S. GOVERNMENT PRINTING OFFICE: 1988-04-18



**PAGE 20 OF 25**

PREVIOUS EDITION WILL BE USED

# WORK CONTROL DOCUMENT (RED)

PAGE 1 OF 1

2. JOB ORDER NO 21033N		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED 89035		6. DATE COMPLETED 4 4	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. UPPER PLANE WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69	073	INSTALL SHAFT HOLE (SMALL) BUSHING WITH MIL-C-16173D COMPOUND .0003-.001 PRESS FIT .7490-.7505 ID *C/P MOVE					001 MNRA		
							002 02		
							003 BE01		
69	074	MACHINE SHAFT HOLE BUSHING (LARGE) FROM 7075-T6/6061-T6 ALUM					001 MNRA		
							002 02		
							003 LE02		
69	075	INSTALL SHAFT HOLE (LARGE) BUSHING WITH MIL-C-16173D COMPOUND .0003-.001 PRESS FIT .8120-.8135 ID *C/P MOVE					001 MNRA		
							002 02		
							003 BE01		
69	076	MACHINE BEARING BORE BUSHING FROM 7076-T6/6061-T6 ALUM					001 MNRA		
							002 02		
							003 LE06		
69	077	INSTALL BEARING BORE BUSHING WITH MIL-C-16173D COMPOUND .0003-.001 PRESS FIT 3.3465-3.3475 ID RECORD WEAR DIM IF REWORK LIMITS ARE EXCEEDED					001 MNRA		
							002 02		
							003 BE01		
		RECORD REASON & CAUSE FOR EXCEEDING REWORK LIMITS *C/P MOVE							
69	078	INSTALL INSERTS (4EA) *C/P MOVE P/N MS124738					001 MNRA		
							002 02		
							003 BE01		
3405	080	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNPGP		
	*REQD*						002 01		
							003 H006		
3405	090	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNPGP		
	*REQD*						002 01		
							003 H006		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT			
DISPATCH	FUNCTIONAL CODE	A				C			

2. JOB ORDER NO <b>21034N</b>	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED <b>89050</b>	6. DATE COMPLETED <b>1</b>
7. PART NUMBER		8. TECH DATA <b>MNPGP</b>		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER <b>4S-1-182</b> <b>4S1-93-3 AND SUPPLEMENTS</b>	12. OPTIONAL <b>17575A</b>
13. SERIAL NUMBER <b>C-5A MLG</b>	14. NOUN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. ANCHOR SHOWN TIME ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
<b>P/N</b>		<b>NON C/N</b>			<b>7</b>
<b>4613366-101A</b>		<b>1620002284716LE 17575A</b> <b>17576A</b> <b>17577A</b> <b>17578A</b>			<b>8</b>
		<b>*****COST: \$297.98*****</b>			
		<b>GOVERNING DIRECTIVES: AFLCR 66-51</b> <b>MANOI 66-3</b> <b>IWD PLATE IAW MIL-C-83488A</b> <b>FMPI IAW MIL-STD-1949</b>			
		<b>P/O N01541</b> <b>STRIP CHROME IAW MIL-STD-871</b> <b>GRIND IAW MIL-STD-865</b> <b>TEMPER ETCH IAW MIL-STD-867</b>			
		<b>SHOT PEEN IAW MIL-S-13165</b> <b>FPI IAW MIL-STD-6866</b> <b>CAD PLATE IAW MIL-STD-870</b> <b>CHROME PLATE IAW MIL-STD-1501</b>			
		<b>BAKE IAW 4S-1-182</b> <b>MANOI 74-12</b> <b>ALDINE IAW MIL-C-8541</b>			
		<b>MATERIAL 4800 ALL 100-000-000-000 4S</b> <b>OR 3000 250,000-300,000 KSI</b>			
		<b>ALL PERSONNEL INVOLVED IN THE WORK</b>			
		<b>PROCESSES SPECIFIED IN THIS DOCUMENT</b>			
		<b>HAVE BEEN THOROUGHLY TRAINED AND ARE</b>			
		<b>FAMILIAR WITH ALL PERTINENT SAFETY</b>			
		<b>PRACTICES AND HAZARDS CONTAINED IN</b>			
		<b>THE BASIC TECHNICAL ORDER (T.O.) AND</b>			
		<b>T.O. SUPPLEMENTS REFERENCED IN BLOCK</b>			
		<b>8 OF THIS AFLC FORM 959. THE</b>			
		<b>APPLICABLE T.O.'S AND SUPPLEMENTS</b>			

21. FINAL DESTINATION WILL ALWAYS COORDINATE WITH ORIGINATOR		22. DOCUMENT NO.	
DISPATCH	FUNCTIONAL CODE	THIS DOCUMENT (CONTINUED)	
			<b>11034N</b>



		*COMPONENTS WILL BE THOROUGHLY
		CLEANED & PROTECTED (C/P MOVE FOR
		MOVES BETWEEN OPERATIONS/DISPATCH
		STATIONS.
		WARNING
		MANY OF THE FOLLOWING REPAIR
		PROCEDURES REQUIRE THE USE OF
		EQUIPMENT, PROCESSES & CHEMICALS
		WHICH ARE POTENTIALLY DANGEROUS TO
		PERSONNEL. ADEQUATE SAFEGUARDS AND
		PRECAUTIONS MUST BE EMPLOYED TO
		PRECLUDE INJURIES.
		*REQD* (MANDATORY REQUIREMENT) IN
		COLUMN 16 IS EQUIVALENT TO DELTA
		STAMP.
	001	4013366-101A
	002	DISASSEMBLE
		C/P MOVE

**11 DATE**

PAGE 6 OF 10 PAGES

PREVIOUS EDITION WILL BE USED

# WORK CONTROL DOCUMENT (MEDS)

DATE

PAGE OF PAGES

2. JOB ORDER NO 21034N		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED 89050		6. DATE COMPLETED 4	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. ANCHOR SHOW WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "O"	
24	055	VAPOR DECREASE *C/P MOVE					001 MNPRC		
							002 02		
							003 BG01		
24	060	STRIP CHROME FROM LARGE AND/OR SMALL JOURNALS. *NOTE* IF ONE JOURNAL IS DEFECTIVE, BOTH JOURNALS MUST BE REWORKED. *C/P MOVE					001 MNPRC		
							002 02		
							003 SC02		
24	070	STRIP CHROME FROM TAPERED AREA O.D. IF NOT PREVIOUSLY ACCOMPLISHED *C/P MOVE					001 MNPRC		
							002 02		
							003 SC02		
24	080	157 BRAND BALL JOURNAL TO CLEAN-UP 1.7021 MINIMUM *C/P MOVE					001 MNPRC		
							002 02		
							003 BG01		
24	090	157 BRAND BALL JOURNAL TO CLEAN-UP 1.70577 MINIMUM *C/P MOVE					001 MNPRC		
							002 02		
							003 BG01		
		*C/P MOVE					001 MNPRC		
		TIME OUT DATE OUT					002 06		
		***** NOTE *****					003 TEC3		
		IF LAST NDI OPERATION IS COMPLETED*							
		HERE, TAKE PRODUCTION COUNT *							
		*****							
24B	110	BAKE 4 HRS AT 375-400F WITHIN 8 HRS OF ETCH.					001 MNPRC		
							002 02		
							003 BK01		
		DATE IN TIME IN							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	OUT TIME OUT							
		(CONTINUED)							
						21034N			

289

2. JOB ORDER NO 21034N		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED 89050		6. DATE COMPLETED 5	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. ANCHOR SHANK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
		RADIUS OF TAPERED AREA					001 MNFNA		
		IS CRITICAL. *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *				M	002 06 003 MLO4		
26	125	VAPOR DECREASE *C/P MOVE					001 MNPRC		
							002 03 003 DBO1		
26	130	SHOTPEEN LARGE JOURNAL .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	131	SHOTPEEN SMALL JOURNAL .008-.012 A2 *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	132	SHOTPEEN TAPERED AREA U.U. .008-.0106. *REDD* *C/P MOVE					001 MNPRC 002 01 003 SP02		
26	133	PREPARE JOURNALS FOR CHROME PLATE, MASK/FIXTURE/ETC *C/P MOVE					001 MNPRC 002 02 003 BE01		
26	137	PREPARE JOURNALS FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BLO4		
26	140	CHROME PLATE LARGE JOURNAL					001 MNPRC 002 03 003 CP01 008 CD010		
21. FINAL DESTINATION TYPE		22. CLASSIFICATION		23. INITIATING RCC SIGNATURE/DATE		24. DOCUMENT/BR			
DISPATCH	FUNCTIONAL CODE	CLIENT TO GRIND BACK TO 1.936 (CONTINUED)				21034N			

TIME OUT \_\_\_\_\_ DATE OUT \_\_\_\_\_  
\*C/P MOVE \_\_\_\_\_

CHROME PLATE SMALL JOURNAL

TYPE II CLASS III

TIME OUT \_\_\_\_\_ DATE OUT \_\_\_\_\_

\*C/P MOVE \_\_\_\_\_

BAKE 4 HRS AT 275-400F

WITHIN 4 HRS OF CHROME

DATE IN \_\_\_\_\_ TIME IN \_\_\_\_\_

DATE OUT \_\_\_\_\_ TIME OUT \_\_\_\_\_

\*C/P MOVE \_\_\_\_\_

~~CHROME PLATE SMALL JOURNAL~~

1.935/1.936. 63 RMS FINISH OR

BETTER. CHROME MAY SHADE OUT

.080 MAX FROM EDGES.

RECORD WEAR DIM IF REWORK LIMITS ARE  
EXCEEDED \_\_\_\_\_

RECORD REASON & CAUSE FOR EXCEEDING  
REWORK LIMITS \_\_\_\_\_

\*C/P MOVE \_\_\_\_\_





# WORK CONTROL DOCUMENT (MEDS)

PAGE 02 PAGES

2. JOB ORDER NO 21034N	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED 89050	6. DATE COMPLETED 9 9
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. ANCHOR SHWPK TRIBE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
----------------------	--------------------	-------------------------------------	--------------	---------	---------

001 MNPRA

AND FINISH I.D. IAW TO 451-93-3  
125 RMS \*C/P MOVE

002 02  
003 BEC1

001 MNPRA

\*C/P MOVE

002 02  
003 BEC1

001 MNP6P

\*REQD\* \*C/P MOVE

002 09  
003 WB03

001 MNP6P

\*REQD\* DOCUMENT FOR COMPLETENESS & ACCURACY  
OF ALL PRECEDING OPERATIONS THIS YOB

002 01  
003 MU06

001 MNP6P

\*REQD\* FINAL PRODUCT VISUAL INSPECTION

\*C/P MOVE

002 01  
003 MU06

21. FINAL DESTINATION 22. COORDINATION/INITIATING RCC SIGNATURE/DATE 23. DOCUMENT/SN

DISPATCH FUNCTIONAL CODE A C

B D

21034N 294



## 21035N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89035

PAGE 1 OF 1 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC MNPGR	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA 45-1-182 451-93-3 AND SUPPLEMENTS	9 ITEM SERIAL NO
---------------	---	------------------

10 MODEL-DESIGN-SERIES 05A MLG	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN COLLAR LOCK INSERT	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4613563-103A		NSN C/N 1620005168457 17575A 17576A 17577A 17578A			
		*****COST: \$1335.01***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 IND PLATE IAW MIL-C-83488A FMPI IAW MIL-STD-1949 P/O N01561 TEMPER ETCH IAW MIL-STD-867 CAD PLATE IAW MIL-STD-870 45-1-182 BAKE IAW 45-1-182 MAOI 74-12 ALODINE IAW MIL-C-5541			
		**MAT'L 300M 280,000-300,000 KSI ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 959. THE APPLI- CABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21035N
		B	D	

## 21035N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89035

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN COLLAR LOCK INSERT						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 O	
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	4613563-103A							
	005 *REQD*	DISASSEMBLE *C/P MOVE					M		
	*REQD*	CHEM CLEAN *C/P MOVE					M		
	*REQD*	BLAST CLEAN *C/P MOVE					M		
	*REQD*	BAKE 4 HRS AT 350-400F							
	*REQD*	DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
	*REQD*	*C/P MOVE				M	K		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21035N			
		B		D					

296

## 21035N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89035

PAGE 3 OF 3 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN COLLAR LOCK INSERT						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		E & I CHECK ALL AREAS FOR DAMAGE AND CORROSION. REMOVE MINOR NICKS AND DEFECTS. *REQD* *C/P MOVE							
		ALL REWORKED AREAS TIME OUT _____ DATE OUT _____ *C/P MOVE				M	K		
		***** N O T E ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****							
26B	060	BAKE 4 HRS AT 350-400F WITHIN 8 HRS DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
		*C/P MOVE ***** N O T E ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****				M	K		
26	072	VAPOR DEGREASE *C/P MOVE							
26	074	STRIP CAD *C/P MOVE							
26	076	STRIP RUST *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21035N			
		B		D					

2. JOB ORDER NO. 1652A		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER 4694034-101A				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES OSA HLG		11. STOCK NUMBER 1620001486466		12. OPTIONAL 1603-2-80-3 46-1-182 AND SUPPLEMENTS					
13. SERIAL NUMBER		14. NOUN BALL SCREW ASSY.							
15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3							
		ALL PERSONNEL INVOLVED IN THE WORK							
		PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN							
		THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION							
		WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/ DISPATCH STATIONS.							
		WARNING							
		MANY OF THE FOLLOWING REPAIR							
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	4694034-101A							
3405	010	*MATCH-UP* -----ROUTED COMPONENTS----- NEW/SERVICEABLE      REWORK      NO REWORK (CONTINUED)						001 MNP GP 002 01 003 MU06	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21069N			
		B		D					

## 21069N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN BALL SCREW ASSY.						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		BALLSCREW 21065N BALL NUT							
		21066N DOG STOP 21067N HEX NUT							
		21068N							
3405	015 *REQD*	INSURE BALL NUT AND BALLSCREW ARE A MATCHED SET						001 MNPBP 002 01 003 MU06	
3405	020 *REQD*	PRE ASSEMBLY INSPECTION INSPECT ALL COMPONENTS FOR GENERAL CONDITION * NOTE: * BALL BEARINGS WILL BE						001 MNPBP 002 01 003 LA02	
		REPLACED 100% AT EACH OVERHAUL. REPLACEMENT BALLS MUST HAVE A DIAMETER EQUAL TO OR GREATER THAN THE DIAMETER OF BALLS REMOVED AT							
		DISASSY.							
3405	025 *REQD*	INSTALL FELT SEALS IN SCRAPERS AND INSTALL A NEW "O" RING ON THE SCRAPER WITH THE "O" RING GROOVE. INSTALL 4 EA SCRAPER DRIVE PINS IN						001 MNPBP 002 01 003 LA02 004 PA0003	
		BORE OF BALLNUT							
3405	030 *REQD*	ASSEMBLE - NOTE: BALLS MUST BE EQUAL TO OR GREATER THAN BALLS REMOVED AT DISASSEMBLY - ALSO, BALLS MUST BE (CONTINUED)				M		001 MNPBP 002 01 003 LA02 004 PA0003	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
ATCH	FUNCTIONAL CODE	A		C		21069N			
		B		D					

## 21069N WORK CONTROL DOCUMENT (MEDS)

1 DATE  
89043

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN BALL SCREW ASSY.						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		THE SAME SIZE. (DO NOT MIX SIZES) AND REPLACED 100%							
34C5	035 *REQD*	INSTALL SELECTED BALLS IN COUNTER BORE HOLES ONE CIRCUIT AT A TIME, BY DROPPING IN SEVERAL BALLS AT A TIME AND ROTATING THE SCREW WHILE					001 MNP GP	002 01	
		HOLDING NUT STATIONARY TO MAKE ROOM FOR MORE BALLS. *****N O T E***** EACH OF THE TWO OUTER CIRCUITS OF						003 LA02	
		2 2/3 TURNS HOLD FROM 55 TO 57 BALLS. THE CENTER CIRCUIT OF 3-2/3 HOLDS 74 TO 76 BALLS						004 PA0003	
34C5	040 *REQD*	WHEN CIRCUIT IS FULL INSTALL REMAINDER OF BALLS IN RETURN TUBES FILL BOTH ENDS WITH GREASE TO KEEP BALLS FROM FALLING OUT.					001 MNP GP	002 01	
		OF THE NUT.						003 LA02	
								004 PA0003	
34C5A	045 *REQD*	INSERT SHORT TUBES INTO TUBE HOLES OF FILLED CIRCUITS AND PRESS OR TAP GENTLY TO SEAL ENDS OF TUBS IN BOTTOM OF TUBE HOLES IN BALL NUT.					001 MNP GP	002 01	
		HOLD IN PLACE WITH TAPE.						003 LA02	
								004 PA0003	
34C5A	050 *REQD*	LOAD THE COUNTER BORE OF THE CENTER CIRCUIT AND FILL THE LONG TUBE AND GENTLY PRESS INTO BALLNUT. REMOVE TAPE AND HEXNUTS AND POSITION CLAMP					001 MNP GP	002 01	
		OVER TUBES AND SECURE HEXNUTS.						003 LA02	
								004 PA0003	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21069N			
		B		D					

## 21069N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 4 OF 4 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN BALL SCREW ASSY.						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
34C5	055 *REQD*	USING A DIAL INDICATOR, CHECK BACK LASH APPLY AN AXIAL FORCE OF APPROX 50 LBS. SET DIAL INDICATOR ON FACE OF BALLNUT AND ZERO THE SUM OF READING MUST NOT EXCEED 0.040					001 MNP GP 002 01 003 LA02 004 PA0003		
34C5	060 *REQD*	SAFETY WIRE THE HEXNUTS SECURING THE DEFLECTOR YOKES. APPLY SEALER AROUND BALL RETURN TUBES WITH PR-1422 AE OR EQUIVALENT AND ALLOW TO CURE 24 HOURS.					001 MNP GP 002 01 003 LA02 004 PA0003		
34C5	065 *REQD*	INSTALL A NEW 90 DEGREE ZERK AND FILL BALLNUT WITH GREASE (81322) UNTIL A SMALL AMOUNT COMES OUT THE BOTTOM OF BALLNUT.					001 MNP GP 002 01 003 LA02 004 PA0003		
34C5	070 *REQD*	FUNCTIONAL TEST ROTATE BALLNUT BY HAND THROUGH ONE FULL STROKE IN BOTH DIRECTIONS. THE UNIT SHOULD OPERATE SMOOTHLY WITH NO KNOCKS OR CLICKS HEARD OR FELT.					001 MNP GP 002 01 003 LA02 004 PA0003		
34C5	075 *REQD*	APPLY A THIN COAT OF GREASE MIL-6-81322 TO ENTIRE LENGTH OF SCREW. APPLY A COAT OF EMRALON AMS - 3136 NO 310 OR EQUIVALENT TO THE TOP 7.5 INS OF SCREW.					001 MNP GP 002 01 003 LA02 004 PA0003		
34C5	080 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY ALL PRECEDING OPERATIONS THIS 958.					001 MNP GP 002 01 003 LA02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE							
ATCH		FUNCTIONAL CODE		A				C	
				B				D	

PREVIOUS EDITION WILL BE USED



2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC MNPOP		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C-5A MLC		11. STOCK NUMBER		12. OPTIONAL AF DWG 7926445 481-93-3 481-182					
13. SERIAL NUMBER		14. NOUN PISTON SUB-ASSY		17687 17575					
18. DISPATCH STATION	19. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. ...	20.	
P/N 7926445		NSN C/N 1620010805925 17687A 17575A <del>17575A</del> 17577A 17578A						4 7 8	
		GOVERNING DIRECTIVES: AFMOR 66-51 MANUL 66-3							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.							
		COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, TOOLS, AND CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP							
	001	7926445							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21088N			
		B		D					

21088N WORK CONTROL DOCUMENT (MEDS)				1 DATE 89043		2 PAGE 2 OF 2 PAGES	
2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.	
7. PART NUMBER		8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL			
13. SERIAL NUMBER		14. NOUN					
15. DISPATCH STATION		16. PERP RCC/OP NO.		17. WORK TO BE ACCOMPLISHED		18. MECHANIC	
						19. "P"	
						20. "Q"	
				* *MATCH - DR* *			001 MNP01
				NEW/SERVICEABLE REWORKED NO REWORK			002 01
				INNER CYL			003 MU06
				21002N FLOATING PISTON			
				21047N PISTON BARRIER			
				21050N PISTON STOP TUBE			
				21043N METERING TUBE BASE			
				21053N GAUGE			
				21054N			
	015			PREASSEMBLY CLEANING: INSPECT ALL CAVITIES AND PASSAGES FOR CLEANLINESS AND SCRATCHES OK TO ASSEMBLE/OR CLOSE			001 MNP01
	*REDD*						002 01
							003 PA07
	020			ASSEMBLE TOGETHER ALL PARTS REQUIRED TO BUILD THE HIGH PRESSURE PISTON ASSY AND INSTALL INTO INNER CYL			001 MNP01
	*REDD*						002 01
							003 PA07
	025			POUR APPROX 1 PT LIGHT OIL INTO LOWER CHAMBER. PLACE GUAGE INTO TEST FIXTURE AND SECURE.			001 MNP01
	*REDD*						002 01
							003 PA07
	030			CHARGE PISTON SUBASSY WITH 2100 PSI AND TEST IAD 401-73-2 PARA 6-6 PAGE 6-10			001 MNP01
	*REQ*						002 01
							003 PA07
							004 PA0001
	035			RECORD LEAKAGE; 1ST HOUR _____ 2ND HOUR _____			001 MNP01
	*REQ*			3RD HOUR _____ 4TH HOUR _____			002 01
							003 PA07
							004 PA0001
	040			UPON COMPLETION OF TEST, DRAIN OFF NITROGEN AND SAFETY WIRE AS REQUIRED *C/P MOVE			001 MNP01
	*REQ*						002 01
							003 PA07
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN	
ATCH		FUNCTIONAL CODE		A		21088N	
				B			
				C			
				D			

16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED
045 *REQD*	CLEAN, MASK AND PAINT IAW 481-162 AND SUPPLEMENTS
050 *REQD*	DECAL AS REQUIRED *C/P MOVE
055 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 951
060 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE

21098N WORK CONTROL DOCUMENT (MEDS)				1 DATE 89043		PAGE 1 OF 1 PAGES	
2. JOB ORDER NO. 652A		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED.	
6. DATE COMPLETED		7. PART NUMBER 4G94034-101A		8. TECH DATA 16G3-2-80-3 4S1-182		9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C5A MLG		11. STOCK NUMBER 1620001486466		12. OPTIONAL			
13. SERIAL NUMBER		14. NOUN BALLSCREW DISASSY					
15. DISPATCH STATION		16. PERF RCC/OP NO.		17. WORK TO BE ACCOMPLISHED		18. MECHANIC	
				GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
				*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
				*****W A R N I N G***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
				*REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
		001		4G94034-101A			
34C5		015 *REQD*		CUT SAFETY WIRE AND REMOVE HEX NUT AND DOG STOP FROM END OF BALLSCREW		001 MNP GP 002 01 003 SD03	
34C5		020 *REQD*		ROTATE BALLNUT OFF THE END OF THE BALLSCREW AND REMOVE ALL THE BALL BEARING FROM I.D. OF BALLNUT		001 MNP GP 002 01 003 SD03	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN			
DISPATCH		FUNCTIONAL CODE		A		C	
				B		D	
						21098N	

## 21098N WORK CONTROL DOCUMENT (MEDS)

DATE 89043

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCH'D.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN BALLSCREW DISASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
34C5	025 *REQD*	REMOVE GREASE FROM BALL BEARINGS AND RECORD THE SIZE OF THE BALLS FOR REFERENCE UPON REASSEMBLY OF BALL-SCREW.					001 MNP GP 002 01 003 SD03		
34C5	030 *REQD*	CLEAN SEALANT FROM RETURN TUBES AND TUBE STRAP, CUT SAFETY WIRE AND REMOVE HEX NUT HOLDING DEFLECTOR YOKES. REMOVE SCRAPERS AND DRIVE PINS AND RETURN TUBES.					001 MNP GP 002 01 003 SD03		
34C5	035 *REQD*	SCRAPE SEALANT FROM BALLNUT TO REMOVE AS MUCH AS POSSIBLE. REMOVE ZERK FITTING AND REMOVE "D" RING AND DISCARD.					001 MNP GP 002 01 003 SD03		
34C5	040 *REQD*	REMOVE EXCESS GREASE FROM BALLNUT AND ATTACH WORK CONTROL DOCUMENTS & ROUTE.					001 MNP GP 002 01 003 SD03		
34C5	045 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNP GP 002 01 003 SD03		
34C5	050 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNP GP 002 01 003 SD03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
ATCH	FUNCTIONAL CODE	A		C		21098N			
		B		D					

## 21089N WORK CONTROL DOCUMENT (MEDS)

DATE 89043

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA 4S1-93-3 4S1-182				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C-5A			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN HLG STRUT-DISASSY						
15. DISPATCH STATION P/N		16. PERF RCC/OP NO.		17. WORK TO BE ACCOMPLISHED NSN C/N				18. MECHANIC	
4G11020-107A				1620010054191 17575A					
4G11020-105A				1620010054192 17576A					
4G11020-101A				1620010054193 17577A					
4G11020-103A				1620010054194 17578A					
				GOVERNING DIRECTIVES: AFLOR 66-51 MANOI 66-3					
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.					
				*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.					
				*****W A R N I N G***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.					
				*REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP					
				YOKE SERIAL NUMBER. _____					
				OUTER SERIAL NUMBER. _____					
				(CONTINUED)					
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE					23. DOCUMENT/SN	
DISPATCH		FUNCTIONAL CODE		A		C		21089N	
				B		D			

## 21089N WORK CONTROL DOCUMENT (MEDS)

DATE 89043

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PAGE NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN MLG STRUT DISASSY						
15. DISPATCH STATION	16. PERFORMER/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		INNER CYL SERIAL NUMBER _____							
		SPLINED TUBE SERIAL NO. _____							
		ROLL PIN SERIAL NUMBER _____							
	001	4G11020-107A 4G11020-105A 4G11020-101A 4G11020-103A							
3405	005 *REQD*	OPEN SHIPPING CRATE AND REMOVE TIE DOWN STRAPS FROM CRADLES. REMOVE APEX PIN, SIDE BRACE ARMS AND ATTACHING HARDWARE FROM STRUT.					001 MNP GP 002 01 003 CC22		
		ATTACH WORK CONTROL DOCUMENT AND ROUTE.							
3405	010 *REQD*	WITH A STRAP HOLD THE INNER CYL IN COLLAPSED POSITION. ATTACH LIFTING SLING THROUGH THE ROLL PIN AND LIFT STRUT TO THE VERTICLE POSITION UP SIDE DOWN.					001 MNP GP 002 01 003 CC22		
3405	015 *REQD*	REMOVE "Y" BLOCK AND DRAIN HYDRAULIC FLUID FROM UPPER CHAMBER INTO A WASTE OIL DRUM. REMOVE TRUNNION PIN AND RETRACT ARM ASSY. DISASSEMBLE RETRACT ARM. ATTACH WCD AND ROUTE					001 MNP GP 002 01 003 CC22		
3405	020 *REQD*	ROLL STRUT INTO UPRIGHT POSITION AND MOVE INTO DISASSEMBLY STAND. BE SURE LOWER CHAMBER HAS NO AIR IN (CONTINUED)					001 MNP GP 002 01 003 SD03 004 PM5573		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
ATCH	FUNCTIONAL CODE	A		C		21089N			
		B		D					

## 21089N WORK CONTROL DOCUMENT (MEDS)

DATE 89043

PAGE 3 OF 3

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN MLG STRUT DISASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		IT. (REMOVE ROLL POSITIONERS, CLEAN AND TAG COND "F".							
34C5	025 *REQD*	REMOVE ROLL PIN AND ATTACHING PARTS. REMOVE FLUID TRANSFER HOUSING., ATTACH WCD'S AND ROUTE. REMOVE STAND PIPE, FLEX HOSE, AND JUNCTION BOX.					001 MNP GP 002 01 003 SD03 004 PM5573		
34C5	030 *REQD*	REMOVE ALL HYD LINES AND TUBING FROM THE KNEELING SYSTEM. REMOVE THE HYD MOTOR, HYD BRAKE AND GEAR BOX. DRAIN HYD FLUID CLEAN AND CAP. TAG COND "F".					001 MNP GP 002 01 003 SD03 004 PM5573		
34C5	035 *REQD*	REMOVE CHAIN COVER, KNEELING CHAINS, GEAR DRIVE HOUSING. DISASSEMBLE THE GEAR DRIVE HOUSING. ATTACH WCD'S AND ROUTE.					001 MNP GP 002 01 003 SD03 004 PM5573		
34C5	040 *REQD*	REMOVE NORM & ENG ROTATION CYLS. DRAIN, CAP AND CLEAN. TAG COND "F". REMOVE ALL HYD TUBING AND FLEX HOSES TO CROSS WIND CYLS. CLEAN TUBING AND HOSES AND STORE FOR REUSE.					001 MNP GP 002 01 003 SD03 004 PM5573		
		* * * * * N O T E * * * * *							
		ON COMPONENTS BEING STORED FOR REUSE VISUALLY INSPECT FOR CLEANLINESS AND SERVICEABILITY BEFORE STORING							
34C5	045 *REQD*	DISCONNECT ELECT WIRES AT ELECT JUNCTION BOX. REMOVE LINEAR SHUTOFF VALVES FROM BRACKETS. DRAIN, CAP, (CONTINUED)					001 MNP GP 002 01 003 SD03 004 PM5573		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21089N			
		B		D					



		<p>***** N O T E *****</p> <p>USE CARE IN REMOVING ELECT. WIRING HARNESS TO AVOID DAMAGE. ELECT WIRING HARNESS SHOULD BE REUSED.</p> <p>*****</p>
34C5	050	<p>REMOVE AND CLEAN ID'S OF CROSS WIND APEX BOLT AND ANTI ROTATION BOLTS. ATTACH WCD'S AND ROUTE. REMOVE AND <del>DRAIN, CAP AND CLEAN</del> CROSS WIND CYLS, NORM &amp; EMG LOCK CYLS TAG F CONDITION.</p>
34C5	055	<p>REMOVE ALL HYD TUBING AND FLEX LINE IN SEQUENCE, ALL HYD FITTINGS AND VALVES. CLEAN AND <del>AND</del> STORE FOR REUSE. REMOVE ELECT. WIRING HARNESS, SYNCHRO TRANS. ATTACH WCD'S &amp; ROUTE</p>
34C5	060	<p>REMOVE ROTATION SHAFTS, BRACKETS AN COVERS, BALLSCREW CROSS PINS. REMOV ELECT. INSERT, CROSS WIND AND ROTATION MANIFOLDS. <del>DRAIN, CAP AND CLEAN.</del> TAG COND- "F".</p>

## 21089N WORK CONTROL DOCUMENT (WCD)

PAGE 01 PAGE

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN MLG STRUT DISASSY						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		AND POSITIONING COLLAR. ATTACH WORK CONTROL DOCUMENTS AND ROUTE.							
34C5	070 *REQD*	UNSCREW PACKING NUT FROM OUTER CYL. DROP THE SPLINED TUBE INTO THE INNER CYL I.D. PLACE INNER CYL IN HOLDING CART AND SEPARATE THE INNER CYL FROM THE OUTER CYL. MOVE FROM UNDER STAND					001 MNP GP 002 01 003 SD03 004 PM5573		
34C5	075 *REQD*	REMOVE OUTER CYL FROM YOKE, AND PLACE IN A "V" CART. REMOVE ALL BUSHINGS. REMOVE BALLSCREWS FROM YOKE AND DISASSEMBLE. ATTACH WCD'S AND ROUTE					001 MNP GP 002 01 003 SD03 004 PM5573		
34C5	080 *REQD*	REMOVE AND DISASSEMBLE SPLINED TUBE. DISASSEMBLE HIGH PRESSURE PISTON ASSEMBLY FROM INNER CYL. REMOVE YOKE ASSY. FROM STAND, CLEAN EXCESS GREASE FROM TRUNNIONS. ATTACH WCD'S AND ROUTE.					001 MNP GP 002 01 003 SD03 004 PM5573		
34C5	085 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY ALL PRECEDING OPERATIONS THIS 958.					001 MNP GP 002 01 003 SD03		
34C5	090 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNP GP 002 01 003 SD03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21089N			
		B		D					

1757EA CEA MLS 4611020-107A

RCC MNPRA

451-93-3

84013

OPER TECH S S W F P F A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STOR	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PRD TIME	STD HOURS	A ELY FCT C
SA009	S	E	JA	EA 1	J 88337	.63	PERCENT ENGR 99.9	REP CEA UPPERSIDE BRACE ARM	10.04		6.32	
0001			JA	01	00	.00		PART NUMBER/NSN	.000	.000	.000	0
0010							4611436-107A	1620001157388				
0030			JA	01	15	1.00		MACH REP BASE LUGS	1.937	.291	2.228	12
0010 E			RML	SU-V3	.50	S/U VERT MIL BORE EXTR HOISTPRO RATE			1.03687		.596	
0015 E			RML	PP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098	
0020 E			RML	AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE			.05917		.068	
0030 E			RML	AL-CC	1.00	ALIGN VERTICAL AXIS MAG BASE			.10721		.140	
0040 E			RML	AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS			.07261		.083	
0050 E			RML	ED-FB	2.00	BORE HOLE 3.5 X 1 GROUP 4 2 LUGS			.53431		1.228	
0060 E			RJP	PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0035			JA	01	15	1.00		BASE LUG FACE REPAIR	1.404	.211	1.615	16
0010 E			RMM	SU-V1	.50	S/U VERT MILL BORE SYAL EXTRPRORATE OVER 2 PARTS			.50518		.290	
0015 E			RML	PP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098	
0020 E			RML	AL-AS	1.00	ALIGN VERTICAL AXIS ROD			.12699		.146	
0040 E			RML	AL-AD	1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0050 E			RML	ED-A	2.00	BORE HOLE 4.5 X 1/2 GROUP 4 2 LUGS			.42654		.981	
0060 E			RJP	PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0040			JA	01	15	1.00		MACH REP APEX LUGS	1.883	.292	2.175	22
0010 E			RML	SU-V3	.50	S/U VERT MIL BORE EXTR HOISTPRO RATE			1.03687		.596	
0015 E			RML	PP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098	
0020 E			RML	AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE			.05917		.068	
0030 E			RML	AL-CC	1.00	ALIGN HOLE TO SPINDLE CLAMP			.06585		.079	
0040 E			RML	AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS			.07261		.083	
0050 E			RML	ED-FB	2.00	BORE HOLE 3.5 X 1 GROUP 4 2 LUGS			.53431		1.228	
0060 E			RJP	PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0045			JA	01	15	1.00		APEX LUG FACE REP	1.881	.292	2.173	22
0010 E			RML	SU-V3	.50	S/U VERT MIL BORE EXTR HOISTPRO RATE			1.03687		.596	
0015 E			RML	PP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098	
0017 E			RML	AL-AS	1.00	ALIGN VERTICAL AXIS ROD			.12699		.146	
0020 E			RML	AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS			.07261		.083	
0030 E			RML	ED-FB	2.00	BORE HOLE 3.5 X 1 GROUP 4			.53431		1.228	
0040 E			RJP	PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0078			JA	01	15	1.00		MACHINE BASE LUG BUSHING	.629	.094	.723	7
0010 E			RLA	SU-S3	.50	SET UP SMALL MEDIUM LATHE PRORATE OVER 2 PARTS			.49962		.287	
0020 E			RLA	PP-C1	4.00	1ST PART IN-GUT SCROLL CHUCK			.01006		.046	
0030 E			RML	TA-SC	4.00	DIA 3.00-4.00 REM .033-.250			.07800		.355	
0040 E			RML	TA-SD	1.00	DIA 4.0 REM .250 ADD INCH			.01707		.019	
0050 E			RJP	PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0080			JA	01	15	1.00		INST BASE LUG BUSHING	.206	.031	.237	2
0010 E			RBW	SU-S1	.50	SET UP TO REBUSH BOSSES PRORATE OVER 2 PARTS			.18669		.107	
0020 E			RBW	SU-A1	2.00	INSTALL SET FLANGED BUSHINGS 4 BUSHINGS			.05133		.116	
0070 E			RJP	PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0088			JA	01	15	1.00		MACHINE APEX LUG BUSHING	.605	.091	.697	7
0010 E			RLA	SU-S3	.50	SET UP SMALL MEDIUM LATHE PRORATE OVER 2 PARTS			.49962		.287	
0020 E			RLA	PP-C1	4.00	1ST PART IN-GUT SCROLL CHUCK 4 BUSHINGS			.01006		.046	
0030 E			RML	TA-EC	4.00	DIA 1.50-2.00 REM .033-.250			.06659		.308	
0040 E			RML	TA-ED	4.00	DIA 2.0 REMOVE .250 ADD INCH			.00947		.043	
0050 E			RJP	PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	
0090			JA	01	15	1.00		INSTALL APEX BUSHING	.185	.028	.214	2
0010 E			RBW	SU-S1	.50	SET UP TO REBUSH BOSSES PRORATE OVER 2 PARTS			.18669		.107	
0020 E			RBW	SU-A4	4.00	INSTALL ONE STRAIGHT BUSHING 4 BUSHINGS			.02062		.094	
0030 E			RJP	PH-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011	

7000 JA 01 00

.00

LABOR STANDARD HISTORY

.000

.000

.000

0

0010

9 JUL 88 INITIAL INPUT MAP11

0020

17 APR 89 BUSHING REMOVAL INCREASED TO 100%

0030

<OLD STD> 3.70

0900

NED MONROE

MANEL

75255

NR 313

70 INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NR0P NR

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17575A CSA MLS 4611020-107A

RCC MNRA

461-93-3

94013

OPER TECH S S 4 F PF A/R REV

SUB	T K	#R	A	FA	SUPPORT	000	DESCRIPTION	BASE	FFD	STD	A				
STEP	D	L	K	C	DC	ELEMENT	FAST	STORED	SUPPLEMENTAL	HOURS	TIME	-DURS	CLY	POT	C

RA013	B	E	JA	EA	1	J	89018	.50	PERCENT ENGR 99.9	C-SA LOWER SIDE BRACE	11.86		5.93		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010										4611435-101A					
										1620001157387					
0070			JA	01	15			1.00		BASE LUG REPAIR	2.043	.007	2.350		20
0010 E						RML-BU-V3		.50	S/U VERT MIL BORE FXTR HOIST	PRORATE	1.03687		.596		
0020 E						RML-HP-AC		.50	HOIST HANDLE NORAP SIMP FXTR	PRORATE	.12195		.070		
0030 E						RML-AL-CA		.50	ALIGN HORIZ AXIS MAG BASE	PRORATE	.05917		.034		
0035 E						RML-AL-CE		.50	ALIGN VERTICAL AXIS MAG BASE	PRORATE	.12351		.071		
0040 E						RML-AL-CC		.50	ALIGN HOLE TO SPINDLE MAG BS	PRORATE	.07261		.041		
0050 E						RML-ED-FB		2.00	BORE HOLE 3 X 1 GROUP 4	2 HOLES	.66725		1.525		
0060 E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0075			JA	01	15			1.00		BASE LUG FACE REPAIR	2.139	.021	2.460		21
0010 E						RML-BU-V3		.50	S/U VERT MIL BORE FXTR HOIST	PRORATE	1.03687		.596		
0015 E						RML-HP-AC		.50	HOIST HANDLE NORAP SIMP FXTR	PRORATE	.12195		.070		
0020 E						RML-AL-CA		.50	ALIGN HORIZ AXIS MAG BASE	PRORATE	.05917		.034		
0030 E						RML-AL-CE		.50	ALIGN VERTICAL AXIS MAG BASE	PRORATE	.12351		.071		
0040 E						RML-AL-CC		.50	ALIGN HOLE TO SPINDLE MAG BS	PRORATE	.07261		.041		
0050 E						KMM-HV-AE		64.00	TRAVERSE 1 INCH-MILLING MACHS	INCH/2 PASSES/4 FACES	.02222		1.535		
0060 E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080			JA	01	15			1.00		APEX REPAIR	1.783	.268	2.054		17
0010 E						RML-BU-V3		.50	S/U VERT MIL BORE FXTR HOIST	PRORATE/2 OPERATIONS	1.03687		.596		
0020 E						RML-HP-AC		.50	HOIST HANDLE NORAP SIMP FXTR	PRORATE 2 OPER.	.12195		.070		
0030 E						RML-AL-CA		.50	ALIGN HORIZ AXIS MAG BASE	PRORATE 2 OPER.	.05917		.034		
0040 E						RML-AL-CE		.50	ALIGN VERTICAL AXIS MAG BASE	PRORATE 2 OPER.	.12351		.071		
0050 E						RML-AL-CC		.50	ALIGN HOLE TO SPINDLE MAG BS	PRORATE 2 OPER.	.07261		.041		
0060 E						RML-ED-FB		2.00	BORE HOLE 3.5 X 1 GROUP 4	2 HOLES	.66725		1.525		
0070 E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0085			JA	01	15			1.00		APEX FACE REPAIR	1.783	.268	2.051		17
0010 E						RML-BU-V3		.50	S/U VERT MIL BORE FXTR HOIST	PRORATE 2 OPER	1.03687		.596		
0020 E						RML-HP-AC		.50	HOIST HANDLE NORAP SIMP FXTR	PRORATE	.12195		.070		
0030 E						RML-AL-CA		.50	ALIGN HORIZ AXIS MAG BASE	PRORATE	.05917		.034		
0040 E						RML-AL-CE		.50	ALIGN VERTICAL AXIS MAG BASE	PRORATE	.12351		.071		
0050 E						RML-AL-CC		.50	ALIGN HOLE TO SPINDLE MAG BS	PRORATE	.07261		.041		
0060 E						KMM-HV-AE		48.00	TRAVERSE 1 INCH-MILLING MACHS	INCHES/2 CUTS/4 FACES	.02222		1.225		
0070 E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0138			JA	01	15			1.00		MACHINE BASE LUG BUSHING	.727	.109	.836		7
0010 E						RLA-BU-S3		.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 2 PARTS	.49962		.287		
0020 E						RLA-HP-C1		4.00	1ST PART IN-OUT SCROLL CHUCK	4 BUSHINGS	.01006		.046		
0030 E						KML-TA-HC		4.00	DIA 4.00-5.00 REM .033-.250		.08497		.390		
0040 E						KML-TA-HD		4.00	DIA 5.0 REM .250 ADD INCH		.02165		.100		
0050 E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0140			JA	01	15			1.00		INSTL BASE LUG BUSH	.580	.087	.667		5
0010 E						RBW-BU-S1		.50	SET UP TO REBUSH BOSSES	PRORATE OVER 2 PARTS	.18669		.107		
0020 E						RBW-BU-S1		2.00	REBUSH A SET OF 2 BOSSES	4 BUSHINGS	.25325		.348		
0030 E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0148			JA	01	15			1.00		MACHINE APEX LUG BUSHING	.680	.102	.782		7
0010 E						RLA-BU-S3		.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 2 PARTS	.49962		.287		
0020 E						RLA-HP-C1		4.00	1ST PART IN-OUT SCROLL CHUCK	4 BUSHINGS	.01006		.046		
0030 E						KML-TA-HC		4.00	DIA 3.00-4.00 REM .033-.250		.07900		.353		
0040 E						KML-TA-HD		4.00	DIA 4.0 REM .250 ADD INCH		.01707		.078		
0050 E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0150			JA	01	15			1.00		INSTALL APEX LUG BUSHINGS	.580	.087	.667		5
0010 E						RBW-BU-S1		.50	SET UP TO REBUSH BOSSES	PRORATE OVER 2 PARTS	.18669		.107		

0020 E	RBW-BU-BI	2.00	REBUP-A SET OF 2 BOSSES	4 BUSHINGS	.23835	.548	
0030 E	RJP-PW-R1	1.00	REMOVED PAPERWORK SIGN OFF DOC		.01001	.011	
9000	J4 01	15	.00	LABOR STANDARD HISTORY	.000	.000	.000 0
0010			27AUG85	UPDATED OCCURANCE FACTORS/RESTRUCTURED			
0011				LABOR STANDARD TO MATCH AFLO FORM 958			
0012				WORK PREVIOUSLY DONE ON OPER. 80090			
0013				(OLD STANDARD) 13.42			
0020			21DEC85	UPDATED OCC FACTORS (OLD STD) 9.55			
0030			17APR89	BUSHING REMOVAL INCREASED TO 100%			
0040				(OLD STD) 6.39			
0900				N MONROE MANEAA 73357			

TO INTERROGATE LABOR STANDARDS, INPUT

ROC P60 NR0P NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC MNPRA

4S1-93-3

84013

TH S S W F PF A/R REV

STEP	T K	HR	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PF	STD	A
D L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

1A015	S	E	JA	EA	1	J	88292	.79	PERCENT ENGR 99.9	CSA YOKE	47.21		37.30	
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0
0010									4G11430-113B	1620001753939				
0008			JA	01	15			.58		REMOVE CENTER BUSHING	13.736	1.195	9.162	19
0010	E					RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192		
0020	E					RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E					RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0040	E					RML-BC-LM	6.00	BORE HOLE 6 X 6 GROUP 3	OCC FOR SIZE MINUS FINISH CT	2.07875		14.343		
0050	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0035			JA	01	15			.85		NICK AND BURR LARGE PART	.166	.021	.162	0
0010	E					RLG-RS-N2	1.00	NICK & BURR LGE STRUT PARTS		.15614		.179		
0020	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0037			JA	01	15			.05		REP CHAIN COVER HOLES	.470	.004	.027	0
0010	E					RBW-SU-G1	1.00	S/U FOR BENCH WORK GENERAL		.27525		.316		
0015	E					RBW-TR-H3	3.00	REMOVE / REPLACE HELICOIL	OCC FOR 50% REPLACMENT	.05849		.201		
0020	E					BTL-TD-03	6.00	TAP/DIE CUT W/FGR TO 6IN HDL6 HOLES		.00102		.007		
0030	E					BTL-TD-04	6.00	TAP/DIE REM W/FGR TO 6IN HDL6 HOLES		.00063		.004		
0040	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC.		.01001		.011		
0040			JA	01	15			.25		REMOVE CRACKED LUGS	1.278	.048	.368	1
0010	E					RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOIST	PRORATE OVER 4 PARTS	1.03687		.298		
0020	E					RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E					RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E					RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E					KHM-BA-BG	3.00	BORE HOLE 1.5 X 3.5 GROUP 1		.21626		.746		
0060	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0055			JA	01	15			.16		BALLSCREW SPROCKET BORE	1.763	.042	.324	1
0010	E					RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192		
0020	E					RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP.		.15776		.181		
0030	E					RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0040	E					RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0050	E					RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0060	E					RML-BA-LD	1.00	BORE HOLE 6 X 2 GROUP 1		.30344		.348		
0070	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0060			JA	01	15			.16		BALLSCREW SPROCKET BORE	1.763	.042	.324	1
0010	E					RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192		
0020	E					RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP.		.15776		.181		
0030	E					RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0040	E					RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0050	E					RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0060	E					RML-BA-LD	1.00	BORE HOLE 6 X 2 GROUP 1		.30344		.348		
0070	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0070			JA	01	15			.05		O/S BALLSCREW HOLE/LEFT	1.709	.013	.098	0
0010	E					RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192		
0015	E					RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP.		.15776		.181		
0020	E					RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0030	E					RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0040	E					RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0050	E					RML-BA-HC	1.00	BORE HOLE 4.5 X 1.5 GROUP 1		.24925		.286		
0060	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0080			JA	01	15			.10		O/S BALLSCREW HOLE/RIGHT	1.284	.019	.148	0
0010	E					RML-SU-V3	.59	S/U VERT MIL BORE FXTR HOIST		1.03687		.703		
0015	E					RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP,		.15776		.181		
0020	E					RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0030	E					RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0040	E					RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0050	E					RML-BA-HC	1.00	BORE HOLE 4.5 X 1.5 GROUP 1		.24925		.286		
0060	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		

0050 E	RML-BA-HC	1.00	BORE HOLE 4.5 X 1.5 GROUP 1	.24925	.286	
0060 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0090 JA 01 15		1.00	OVERSIZE HOLE WITH REAMER	.349	.052	.402 1
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
020 E	RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.06831	.078	
0030 E	RBW-BU-R2	3.00	REAM WITH LEMPCO REAMER 3 PASSES	.07337	.253	
0040 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004	
0050 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0100 JA 01 15		1.00	OVERSIZE HOLE WITH REAMER	.349	.052	.402 1
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.06831	.078	
0030 E	RBW-BU-R2	3.00	REAM WITH LEMPCO REAMER 3 PASSES	.07337	.253	
0040 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423	.004	
0050 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0110 JA 01 15		.05	O/S TRUNNION HOLE/LEFT	2.564	.019	.147 0
0010 E	RML-SU-V7	1.00	S/U VERT MIL BORE FXTR HOIST	1.03687	1.192	
0015 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP,	.15776	.181	
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE	.05917	.068	
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE	.12351	.142	
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS	.07261	.083	
0050 E	RML-BA-LM	2.00	BORE HOLE 6 X 6 GROUP 1 OCC FOR 7 IN X 8 IN.	.55232	1.270	
0060 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0120 JA 01 15		.10	O/S TRUNNION HOLE/LEFT	2.106	.032	.242 1
0010 E	RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST	1.03687	1.192	
0015 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP,	.15776	.181	
0020 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE	.05917	.068	
0030 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE	.12351	.142	
0040 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS	.07261	.083	
0050 E	RML-BA-LM	1.17	BORE HOLE 6 X 6 GROUP 1 OCC FOR 7 IN X 8 IN.	.55232	.743	
0060 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0130 JA 01 15		.05	O/S CROSSPIN HOLE/LEFT	.366	.003	.021 0
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18669	.214	
0020 E	RBW-BU-R2	2.00	REAM WITH LEMPCO REAMER 8 PASSES	.07337	.168	
0030 E	RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT	.01603	.018	
0040 E	RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D	.00333	.007	
0050 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0140 JA 01 15		.10	O/S CROSSPIN HOLE/RIGHT	.769	.012	.089 0
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18669	.214	
0020 E	RBW-SU-G1	2.00	S/U FOR BENCH WORK GENERAL PRORATE FOUR PARTS	.27525	.633	
0030 E	RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT	.01603	.018	
0040 E	RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I D	.00333	.007	
0050 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0150 JA 01 15		.05	O/S RETAINER HOLES/LEFT	.601	.005	.035 0
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18669	.214	
0020 E	RBW-BU-R2	4.00	REAM WITH LEMPCO REAMER 4 PASSES	.07337	.337	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES	.10435	.120	
0040 E	RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING I DEXTRA POLISH	.00333	.007	
0050 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0160 JA 01 15		.05	O/S RETAINER HOLES/RIGHT	.607	.005	.035 0
0010 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18669	.214	
0020 E	RBW-BU-R2	4.00	REAM WITH LEMPCO REAMER 4 PASSES	.07337	.337	
0030 E	RBW-BU-C1	1.00	CHAMFER SET OF BUSHING BORES	.10435	.120	
0040 E	RBW-BU-P1	4.00	BUTTERFLY POLISH BUSHING I DEXTRA POLISH	.00333	.015	
0050 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	
10 E JA 01 15		.05	BALLSCREW SPROCKET BORE	1.835	.014	.106 0
0010 E	RML-SU-V3	1.00	S/U VERT MIL BORE FXTR HOIST	1.03687	1.192	
0020 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP,	.15776	.181	
0030 E	RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE	.05917	.068	
0040 E	RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE	.12351	.142	
0050 E	RML-AL-CC	2.00	ALIGN HOLE TO SPINDLE MAG BS	.07261	.167	
0060 E	RML-BA-LD	1.00	BORE HOLE 6 X 2 GROUP 1	.30344	.348	
0070 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001	.011	



0225	JA 01	15	.90	INSTALL INSERTS	.486	.066	.504	1
0010 E		RBW-SU-H1	1.00	SET UP TO INSTALL HELICOILS ,	.31093		.357	
0020 E		RBW-TR-H1	6.00	INSTALL HELICOIL INSERT 6 HOLES	.02763		.190	
0030 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC.	.01001		.011	
0238	JA 01	15	.69	INSTL CENTER BUSH	.355	.037	.282	1
0010 E		RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES	.22231		.255	
0020 E		RLG-UP-O1	1.00	UNPACK-OPEN ANY CONTAINER	.04101		.047	
0030 E		RBW-BU-A4	3.00	INSTALL ONE STRAIGHT BUSHING OCC FOR LRG SIZE	.02062		.071	
0040 E		KNF-SP-O1	1.00	STAKE PART-FIRST LOCATION	.00241		.002	
0050 E		KNF-SP-O2	11.00	STAKE PART EA ADDL LOCATION	.00163		.020	
0060 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0238	JA 01	15	1.00	INST BALLSCREW BUSH/LEFT	.589	.088	.678	1
0010 E		RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE OCC FOR 2 OPERATIONS	.49962		.287	
0020 E		RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS	.02466		.028	
0030 E		KHL-TC-HA	.25	DIA 4.00-5.00 REM (.033 OCC FOR LENGTH/FLANGE	.14789		.042	
0040 E		KHL-TC-HA	1.00	DIA 4.00-5.00 REM (.033 O.D.	.14789		.170	
0050 E		RLA-FF-LE	1.00	FACE FINISH 7 - 8 GROUP 3	.05888		.067	
0060 E		RLA-FF-LF	3.00	FACE FINISH 7-8 ADD 1/8 INCH OCC FOR 3/8 EXTRA TRAVEL	.02059		.071	
0090 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0240	JA 01	15	1.00	INST BALLSCREW BUSH/LEFT	.030	.005	.035	0
0080 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023	
0090 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0248	JA 01	15	1.00	INST BALLSCREW BUSH/RIGHT	.589	.088	.678	1
0010 E		RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE OCC FOR 2 OPERATIONS	.49962		.287	
0020 E		RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS	.02466		.028	
0030 E		KHL-TC-HA	.25	DIA 4.00-5.00 REM (.033 OCC FOR LENGTH/FLANGE	.14789		.042	
0040 E		KHL-TC-HA	1.00	DIA 4.00-5.00 REM (.033 O.D.	.14789		.170	
0050 E		RLA-FF-LE	1.00	FACE FINISH 7 - 8 GROUP 3	.05888		.067	
0060 E		RLA-FF-LF	3.00	FACE FINISH 7-8 ADD 1/8 INCH OCC FOR 3/8 EXTRA TRAVEL	.02059		.071	
0090 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0250	JA 01	15	1.00	INST BALLSCREW BUSH/RIGHT	.123	.019	.143	0
0070 E		RBW-BU-S1	.50	SET UP TO REBUSH BOSSES PRORATE 2 OPERATIONS	.18669		.107	
0080 E		RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023	
0090 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0259	JA 01	15	1.00	INST UPPER SIDE BRACE BUSH	7.342	1.101	8.444	18
0001				BRACE ARM BUSHINGS/BEA				
0002				2 STRAIGHT & 6 FLANGED				
0010 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	.49962		.574	
0020 E		KHL-TC-HA	8.00	DIA 4.00-5.00 REM (.033 FLANGE	.14789		1.350	
0030 E		KHL-TC-GA	8.00	DIA 3.00-4.00 REM (.033 OD	.12496		1.149	
0040 E		RLA-FF-JE	1.50	FACE FINISH 5 - 6 GROUP 3	.05098		.087	
0050 E		RLA-BO-HE	8.00	BORE HOLE 3 1/2 - 4 DIA 1 DP	.44809		4.122	
0060 E		RLA-CD-HE	8.00	CUT OFF 3 1/2 - 4 DIA. GRP 3	.06645		.611	
0070 E		RLA-FR-JE	6.00	FACE ROUGH 5 - 6 DIA. GRP 3	.02519		.173	
0080 E		RLA-FF-JE	6.00	FACE FINISH 5 - 6 GROUP 3	.05098		.351	
0110 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0260	JA 01	15	1.00	INST UPPER SIDE BRACE BUSH	1.150	.173	1.323	3
0001				BRACE ARM BUSHINGS/BEA				
0002				2 STRAIGHT & 6 FLANGED				
0090 E		RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18669		.214	
0100 E		RBW-BU-B1	4.00	REBUSH A SET OF 2 BOSSES 4 SETS OF 2 BUSHINGS	.23835		1.096	
0110 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0269	JA 01	15	1.00	INST LOWER SIDE BRACE BUSH	8.742	1.311	10.054	21
0001				BRACE ARM BUSHINGS/BEA				
0002				2 STRAIGHT & 6 FLANGED				
0010 E		RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE	.49962		.574	
0020 E		KHL-TC-JA	8.00	DIA 5.00-6.00 REM (.033 FLANGE	.17036		1.567	
0030 E		KHL-TC-HA	8.00	DIA 4.00-5.00 REM (.033 OD	.14789		1.360	
0040 E		RLA-FF-LE	1.50	FACE FINISH 7 - 8 GROUP 3	.05888		.101	
0050 E		RLA-BO-JE	8.00	BORE HOLE 4 - 4 1/2 DIA 1 DP	.56243		5.174	
0060 E		RLA-CD-JE	8.00	CUT OFF 4 - 4 1/2 DIA. GRP 3	.07135		.656	

0080 E	RLA-FF-LE	6.00	FACE FINISH 7 - 8 GROUP 3		.05888		.406	
0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0101 JA 01	15	1.00	INST LOWER SIDE BRACE BUSH		1.150	.173	1.323	3
0102			BRACE ARM BUSHINGS/BEA					
0090 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669		.214	
0100 E	RBW-BU-B1	4.00	REBUSH A SET OF 2 BOSSES 4 SETS OF 2		.23835		1.096	
0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0278 JA 01	15	1.00	INST TRUN END HOLE BUSH/LEFT		1.757	.264	2.021	4
0010 E	RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE OCC FOR 2 OPERATIONS		.49962		.287	
0020 E	RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028	
0030 E	KHL-TC-JC	1.00	DIA 5.00-6.00 REM .033-.250		.24985		.287	
0040 E	KHL-TC-JD	8.00	DIA 6.0 REM .250 ADD INCH OCC FOR EXTRA LENGTH		.13553		1.246	
0050 E	RLA-FR-NE	1.00	FACE ROUGH 9 - 10 DIA. GRP 3		.03320		.038	
0060 E	RLA-FR-NF	1.00	FACE ROUGH 9 - 10 ADD 1/8 IN		.01300		.014	
0070 E	RLA-FF-NE	1.00	FACE FINISH 9 - 10 GROUP 3		.06699		.077	
0080 E	RLA-FF-NF	1.00	FACE FINISH 9-10 ADD 1/8 IN.		.02600		.029	
0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0280 JA 01	15	1.00	INST TRUN END HOLE BUSH/LEFT		.123	.019	.143	0
0090 E	RBW-BU-S1	.50	SET UP TO REBUSH BOSSES PRORATE 2 OPERATIONS		.18669		.107	
0100 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0288 JA 01	15	1.00	INST TRUN END HOLE BUSH R.S.		1.757	.264	2.021	4
0010 E	RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE PRORATE 2 OPERATIONS		.49962		.287	
0020 E	RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028	
0030 E	KHL-TC-JC	1.00	DIA 5.00-6.00 REM .033-.250		.24985		.287	
0040 E	KHL-TC-JD	8.00	DIA 6.0 REM .250 ADD INCH OCC FOR EXTRA LENGTH		.13553		1.246	
0050 E	RLA-FR-NE	1.00	FACE ROUGH 9 - 10 DIA. GRP 3		.03320		.038	
0060 E	RLA-FR-NF	1.00	FACE ROUGH 9 - 10 ADD 1/8 IN		.01300		.014	
0070 E	RLA-FF-NE	1.00	FACE FINISH 9 - 10 GROUP 3		.06699		.077	
0080 E	RLA-FF-NF	1.00	FACE FINISH 9-10 ADD 1/8 IN.		.02600		.029	
0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0290 JA 01	15	1.00	INST TRUN END HOLE BUSH R.S.		.123	.019	.143	0
0090 E	RBW-BU-S1	.50	SET UP TO REBUSH BOSSES PRORATE 2 OPERATIONS		.18669		.107	
0100 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0110 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0295 JA 01	15	1.00	CHECK TRUN BUSH/FACE TO FACE		.097	.015	.112	0
0010 E	RJP-TC-A1	1.00	TOOL TO & FROM SHOP CRIB		.06735		.077	
0020 E	RLG-EI-C3	1.00	CHK FACE TO FACE 1/S OR O/S		.01427		.016	
0030 E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION		.00601		.006	
0040 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0298 JA 01	15	1.00	INST L.S. CROSS PIN BUSH		.921	.138	1.060	2
0010 E	RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE PRORATE 2 OPERATIONS		.49962		.287	
0020 E	RLA-HP-C6	2.00	LOAD&UNLOAD SML PART-CENTERS2 BUSHINGS		.02466		.056	
0030 E	KHL-TC-FA	2.00	DIA 2.00-3.00 REM (.033 FLANGE/2 BUSHINGS		.10296		.236	
0040 E	KHL-TC-FA	2.00	DIA 2.00-3.00 REM (.033 O.D./2 BUSHINGS		.10296		.236	
0050 E	KHL-TC-FB	2.00	DIA 3.0 REM .033 ADD INCH 2 BUSHINGS		.04117		.094	
0060 E	RLA-FR-FE	2.00	FACE ROUGH 2.5 - 3 DIA GRP 3		.01957		.045	
0070 E	RLA-FF-FE	2.00	FACE FINISH 2.5 - 3 GROUP 3		.03974		.091	
0100 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0300 JA 01	15	1.00	INST L.S. CROSS PIN BUSH		.921	.138	1.060	2
0010 E	RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE PRORATE 2 OPERATIONS		.49962		.287	
0020 E	RLA-HP-C6	2.00	LOAD&UNLOAD SML PART-CENTERS2 BUSHINGS		.02466		.056	
0030 E	KHL-TC-FA	2.00	DIA 2.00-3.00 REM (.033 FLANGE/2 BUSHINGS		.10296		.236	
0040 E	KHL-TC-FA	2.00	DIA 2.00-3.00 REM (.033 O.D./2 BUSHINGS		.10296		.236	
0050 E	KHL-TC-FB	2.00	DIA 3.0 REM .033 ADD INCH 2 BUSHINGS		.04117		.094	
0060 E	RLA-FR-FE	2.00	FACE ROUGH 2.5 - 3 DIA GRP 3		.01957		.045	
0070 E	RLA-FF-FE	2.00	FACE FINISH 2.5 - 3 GROUP 3		.03974		.091	
0100 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0303 JA 01	15	1.00	INST R.S. CROSS PIN BUSH		1.171	.176	1.348	3
0010 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
			2 STRAIGHT & 6 FLANGED		.02466		.056	

0030 E	KML-TC-FA	2.00 DIA 2.00-3.00 REM (.033	FLANGE/2 BUSHINGS	.10296	.236	
0040 E	KML-TC-FA	2.00 DIA 2.00-3.00 REM (.033	O.D./2 BUSHINGS	.10296	.236	
0050 E	KML-TC-FB	2.00 DIA 3.0 REM .033 ADD INCH		.04117	.094	
0060 E	RLA-FR-FE	2.00 FACE ROUGH 2.5 - 3 DIA GRP 3		.01957	.045	
0070 E	RLA-FF-FE	2.00 FACE FINISH 2.5 - 3 GROUP 3		.03974	.091	
0100 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011	
0310 JA 01	15	1.00	INST R.S. CROSS PIN BUSH	.435	.065	.500 1
0080 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18669	.214	
0090 E	RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES		.23835	.274	
0100 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011	
0318 JA 01	15	1.00	INST L.S. RET BUSH/2 EA	.844	.127	.971 2
0010 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE		.49962	.574	
0020 E	RLA-HP-C6	2.00 LOAD&UNLOAD SML PART-CENTERS		.02466	.056	
0030 E	KML-TC-BA	2.00 DIA .251-.500 REM (.033	FLANGE	.05538	.127	
0040 E	KML-TC-BA	2.00 DIA .251-.500 REM (.033	O.D.	.05538	.127	
0050 E	RLA-FF-BE	2.00 FACE FINISH 1/2 - 1 GROUP 3		.03184	.073	
0080 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011	
0320 JA 01	15	1.00	INST L.S. RET BUSH/2 EA	.435	.065	.500 1
0060 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18669	.214	
0070 E	RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES		.23835	.274	
0080 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011	
0324 JA 01	15	1.00	INST R.S. RET BUSH/2 EA	.844	.127	.971 2
0010 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE		.49962	.574	
0020 E	RLA-HP-C6	2.00 LOAD&UNLOAD SML PART-CENTERS		.02466	.056	
0030 E	KML-TC-BA	2.00 DIA .251-.500 REM (.033		.05538	.127	
0040 E	KML-TC-BA	2.00 DIA .251-.500 REM (.033		.05538	.127	
0050 E	RLA-FF-BE	2.00 FACE FINISH 1/2 - 1 GROUP 3		.03184	.073	
0080 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011	
JA 01	15	1.00	INST R.S. RET BUSH/2 EA	.435	.065	.500 1
0060 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18669	.214	
0070 E	RBW-BU-B1	1.00 REBUSH A SET OF 2 BOSSES		.23835	.274	
0080 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011	
0326 JA 01	15	.05	MFR/INST SPROCKET SLEEVE	1.155	.009	.066 0
0010 E	RLA-SU-S3	1.00 SET UP SMALL MEDIUM LATHE		.49962	.574	
0020 E	RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCKLOAD/MACHINE/REVERSE/MACHINE		.01006	.023	
0030 E	RLA-BO-NA	1.40 BORE HOLE 5 1/2 - 6 DIA 1 DPOCCURRANCE FOR LRG DIAMETER		.27549	.443	
0040 E	KML-TA-JA	1.40 DIA 5.0-6.0 REM (.033	OCCURR FOR LRG DIAMETER	.07105	.114	
0050 E	RLA-FR-NA	2.00 FACE ROUGH 9 - 10 DIA. GRP 1 TWO ENDS		.01783	.041	
0060 E	RLA-FF-NA	2.00 FACE FINISH 9 - 10 GROUP 1 TWO ENDS		.03627	.083	
0070 E	RLA-CO-NA	1.00 CUT OFF 5 1/2 - 6 DIA. GRP 1,		.03269	.037	
0100 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC.		.01001	.011	
0327 JA 01	15	.05	MFR/INST SPROCKET SLEEVE	.217	.002	.012 0
0080 E	RBW-BU-S1	1.00 SET UP TO REBUSH BOSSES		.18669	.214	
0090 E	RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING,		.02062	.023	
0100 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC.		.01001	.011	
0329 JA 01	15	.25	MANUFACTURE REP MEMBER #5	.726	.027	.209 0
0010 E	RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00 1ST PART IN-OUT SCHULL CHUCK		.01006	.011	
0030 E	KML-TD-CC	3.00 DIA .501-1.00 REM .033-.250		.10898	.375	
0040 E	KML-CD-P1	3.00 CENTER DRILL		.01519	.052	
0050 E	RLA-DR-MB	3.00 DRILL HOLE 1/8-1/4 DIA X 1		.05341	.191	
0060 E	GTL-TH-A1	3.00 TAP HOLE TO 0.25 IN THRD DIA		.01427	.049	
0070 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011	
0330 JA 01	15	.25	INST MEMBER 1-6	.079	.003	.023 0
0010 E	RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-A2	1.00 INSTALL SET STRAIGHT BUSHING NO POLISH AVERAGED 2 REP		.02299	.026	
0040 E	RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC		.01001	.011	
9000 JA 01	15	.00	LABOR STANDARD HISTORY	.000	.000	.000 0

12JUL85 RESTRUCTURED LABOR STD TO MATCH AFLC FORM

958/UPDATED OCC FACTORS/WORK PREVIOUSLY

DONE ON OPER B0110 <OLD STD> 42.13

21JAN86 UPDATED OCC FACTORS/ADDED SUB OPER 0165

0021  
0900

AND 0327 <OLD STD> 36.90  
N MONROE KANEAA 73357

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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17575A CSA MLG 4G11020-107A

RCC NMPRA

4S1-93-3

84013

CH S S W F P F A/R REV

T K #R A FA SUPPORT

OCC

&lt;

DESCRIPTION

-----&gt;

BASE

PFD

STD

A

STEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

0016	S	E	JA	EA	1	J	89026	.58	PERCENT ENGR 99.9	MACH POSITIONING COLLAR C5AM	2.40		1.39		
0001			JA	01	00			.00		PART NUMBER / NSN	.000	.000	.000		0
									4G11476-107A	1620005581485					
									4G11476-101B	1620001157415					
0055			JA	01	15			.07		REMOVE PINS	.236	.002	.019		1
								.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.158		
								1.00	PREP HAND DRILL FOR USE		.00861		.009		
								3.00	DRILL & EASYOUT SCR TO .25IN3 PINS		.02540		.087		
								1.00	REM RPL PAPRWRK SIGN OFF DOC		.01427		.016		
0060			JA	01	15			.07		O/S POSITIONER LUG HOLE	.620	.007	.050		2
								.50	SET UP TO REBUSH BOSSES	PRORATE OVER 2 PARTS	.18669		.107		
								1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
								6.00	REAM WITH LEMPCO REAMER	3 PASSES 2 LUGS	.07337		.506		
								2.00	DEBUR HOLE/CUTOUT BOTH SIDES	DEBURR 2 LUGS	.00423		.009		
								1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0070			JA	01	15			.05		O/S CLEVIS LUG HOLE L/S	.620	.005	.036		1
								.50	SET UP TO REBUSH BOSSES	PRORATE OVER 2 PARTS	.18669		.107		
								1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
								6.00	REAM WITH LEMPCO REAMER	3 PASSES 2 LUGS	.07337		.506		
								2.00	DEBUR HOLE/CUTOUT BOTH SIDES	DEBURR 2 LUGS	.00423		.009		
								1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
			JA	01	15			.05		O/S CLEVIS LUG HOLE R/S	.620	.005	.036		1
								.50	SET UP TO REBUSH BOSSES	PRORATE OVER 2 PARTS	.18669		.107		
								1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078		
								6.00	REAM WITH LEMPCO REAMER	3 PASSES 2 LUGS	.07337		.506		
								2.00	DEBUR HOLE/CUTOUT BOTH SIDES	DEBURR 2 LUGS	.00423		.009		
								1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0303			JA	01	15			.14		MACH & FACE PINS	1.301	.027	.210		9
								1.00	SET UP SMALL MEDIUM LATHE		.49962		.574		
								3.00	HAND HANDLE NO WRAP 2 CLAMPS3 PINS		.08531		.294		
								3.00	DIA .251-.500 (.033	FLANGE/3 PINS	.06193		.213		
								3.00	DIA .251-.500 (.033	O.D./3 PINS	.06193		.213		
								3.00	FACE ROUGH 2 - 2.5 DIA GRP 43 PINS		.02116		.073		
								3.00	FACE FINISH 1/2 - 1 GROUP 4 3 PINS TO LENGTH		.03356		.115		
								1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0305			JA	01	15			.14		INSTALL PINS	.210	.004	.034		1
								.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
								3.00	INSTALL SET FLANGED BUSHINGS	INSTALL 3 PINS	.05133		.177		
								1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0308			JA	01	15			1.00		MACH POSITIONER LUG BUSHING	.297	.045	.342		14
								.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
								2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
								2.00	DIA 2.00-3.00 REM .033-.250		.07104		.163		
								1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0310			JA	01	15			1.00		INSTALL POSITIONER LUG BUSH	.295	.044	.339		14
								.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
								1.00	REBUSH & SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
								1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
			JA	01	15			1.00		MACH CLEVIS LUG BUSH L/S	.289	.043	.332		14
								.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
								2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
								2.00	DIA .501-1.00 REM .033-.250	2 BUSHINGS	.06699		.154		
								1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0320			JA	01	15			1.00		INST CLEVIS LUG BUSHING L/S	.295	.044	.339		14
								.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		

0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0328	JA 01	15	1.00		MACH CLEVIS LUG BUSH R/S	.289	.043	.332	14
0010 E		SLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023	
0030 E		KHL-TA-CC	2.00	DIA .501-1.00 REN .033-.250 2 BUSHINGS		.06699		.154	
0040 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0330	JA 01	15	1.00		INST CLEVIS LUG BUSH R/S	.295	.044	.339	14
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274	
0030 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	15	.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0010				27AUG85 NEW OPERATION/WORK PREVIOUSLY DONE ON					
0011				OPER B0060 <OLD STD> 3.58					
0020				31DEC85 UPDATED OCC FACTORS <OLD STD> 3.10					
0900				N MONROE MANEAM 73357					

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-NM1-DY-M45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC MNPRA

4S1-93-3

84013

TECH S S W F PF A/R REV

T K R A FA SUPPORT OCC

STEP D L K C DC ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE  
HOURS

PFD  
TIME

STD  
HOURS

A  
DLY PCT C

RA017	S	E	JA	EA	1	J	88334	.67	PERCENT ENGR 99.9	REP APEX SHAFT C-5A	.54		.36	
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0
0010									4G13561-101A	5315001321925				
0055			JA	01	15			1.00		RECENTER PIN--60--	.472	.071	.543	100
0010	E						RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE 2 PARTS	.49962		.287	
0020	E						RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW	BOTH SIDES	.09095		.209	
0030	E						KHL-CD-P1	2.00	CENTER DRILL		.01519		.034	
0050	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000			JA	01	00			.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0010									9 JUNE 88 INITIAL INPUT MRPII					
0900									NED MONROE	KANEL	73255		MR BIG	

INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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17575A CSA MLG 4G11020-107A

H S S W F P F A/R REV

T K #R A FA SUPPORT

STEP D L K C DC ELEMENT

OCC

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE  
HOURSPFD  
TIMESTD  
HOURSA  
DLY PCT C

0018	S	E	JA	EA	1	J	89017	.83	PERCENT ENGR 99.8	MACH RETRACT ARM C-5A	7.33		6.09		
0001			JA	01	00			.83		PART NUMBER/NSN	.000	.000	.000		0
									4G11448-107A	1620001157390					
0060			JA	01	15			.10		O/S CROSS PIN HOLES	2.344	.035	.270		4
0010	E					RML-SU-V3		1.00	S/U VERT MIL BORE FXTR HOIST	LUCAS BORING MILL	1.03687		1.192		
0020	E					RML-AL-CA		1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0030	E					RML-AL-CB		1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0040	E					RML-AL-CC		1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0050	E					RML-BD-DB		1.00	BORE HOLE 2.5 X 1 GROUP 4		.44325		.509		
0060	N							1.00		ROTATE PART 180 DEGREE	.08300		.095		
0070	E					RML-AL-CC		1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0080	E					RML-BD-DB		1.00	BORE HOLE 2.5 X 1 GROUP 4		.44325		.509		
0100	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0065			JA	01	15			.80		O/S RIG PIN HOLE	1.067	.128	.982		13
0010	E					RML-SU-V2		.50	S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 2 PARTS	.80167		.460		
0020	E					RML-AL-CA		1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0030	E					RML-AL-CB		1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0040	E					RML-AL-CC		1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0050	E					RML-BD-AD		1.00	BORE HOLE 1 X 2 GROUP 4		.40093		.461		
0070	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0070			JA	01	15			.10		O/S SMALL ATTACH HOLE	1.616	.024	.186		3
0010	E					RML-SU-V3		1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192		
0020	E					RML-AL-CA		1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0030	E					RML-AL-CB		1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0040	E					RML-AL-CC		1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0050	E					RML-BD-CA		1.00	BORE HOLE 2 X 1/2 GROUP 4		.31398		.361		
0070	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0080			JA	01	15			.20		O/S LARGE ATTACH HOLE	1.688	.051	.388		5
0010	E					RML-SU-V3		1.00	S/U VERT MIL BORE FXTR HOIST		1.03687		1.192		
0020	E					RML-AL-CA		1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068		
0030	E					RML-AL-CB		1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0040	E					RML-AL-CB		1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142		
0050	E					RML-BD-DA		1.00	BORE HOLE 2.5 X 1/2 GROUP 4		.33548		.385		
0070	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0228			JA	01	15			1.00		TURN BUSHING GROUP 1/BRONZE	.216	.032	.248		3
0010	E					RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E					RLA-HP-C1		1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011		
0030	E					KHL-TA-FC		1.00	DIA 2.00-3.00 REM .033-.250		.07104		.081		
0040	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0230			JA	01	15			1.00		INST SET FLANGED BUSHINGS	.108	.016	.124		2
0010	E					RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E					RBW-BU-A1		1.00	INSTALL SET FLANGED BUSHINGS NO POLISH		.05133		.059		
0030	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0232			JA	01	15			1.00		O/S HOLE ON MILL/MED PART	.831	.125	.957		13
0010	E					RML-SU-V2		.25	S/U VERT MILL BORE LRG FIXTR	PRORATE OVER 4 PARTS	.80167		.230		
0020	E					RML-HP-CC		1.00	HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181		
0030	E					RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E					RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E					KHM-BC-DA		1.00	BORE HOLE 2.5 X 1/2 GROUP 3 USE PROPER ELEMENT/TABLE		.26060		.299		
0060	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0238			JA	01	15			1.00		TURN BUSHING GROUP 1/BRONZE	.289	.043	.332		5
0010	E					RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E					RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
0030	E					KHL-TA-EC		2.00	DIA 1.50-2.00 REM .033-.250		.06699		.154		
0040	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		



0240	JA 01	15	1.00	INST SET FLANGED BUSHINGS	.108	.016	.124	2
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	1.00 INSTALL SET FLANGED BUSHINGS NO POLISH		.05133		.059	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	1.00	O/S HOLE ON MILL/MED PART	.805	.121	.927	13
0010 E		RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS		.80167		.230	
0020 E		RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		KHM-BC-BA	1.00 BORE HOLE 1.5 X 1/2 GROUP 3 USE PROPER ELEMENT/TABLE		.23467		.269	
0060 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0248	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.297	.045	.342	5
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023	
0030 E		KML-TA-FC	2.00 DIA 2.00-3.00 REM .033-.250		.07104		.163	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0249	JA 01	15	1.00	INST SET FLANGED BUSHINGS	.108	.016	.124	2
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	1.00 INSTALL SET FLANGED BUSHINGS NO POLISH		.05133		.059	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0250	JA 01	15	1.00	O/S HOLE ON MILL/MED PART	.787	.118	.906	12
0010 E		RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS		.80167		.230	
0020 E		RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RML-BA-CD	1.00 BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE		.21626		.248	
0060 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0251	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.289	.043	.332	5
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023	
0030 E		KML-TA-CC	2.00 DIA .501-1.00 REM .033-.250 2 BUSHINGS		.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0252	JA 01	15	1.00	INST SET FLANGED BUSHINGS	.108	.016	.124	2
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	1.00 INSTALL SET FLANGED BUSHINGS NO POLISH		.05133		.059	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0253	JA 01	15	1.00	O/S HOLE ON MILL/MED PART	.845	.127	.972	13
0010 E		RML-SU-V2	.25 S/U VERT MILL BORE LRG FIXTRPRORATE OVER 4 PARTS		.80167		.230	
0020 E		RML-HP-CC	1.00 HOIST HANDLE NO WRAP 2 CLAMP		.15776		.181	
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		KHM-BC-AC	1.00 BORE HOLE 1 X 1 1/2 GROUP 3 USE PROPER ELEMENT/TABLE		.27420		.315	
0060 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000	JA 00	15	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				27AUG85 UPDATE OCCURANCE FACTORS/RESTRUCTURED				
0011				LABOR STANDARD TO MATCH AFLC FORM 958				
0012				WORK PREVIOUSLY DONE ON OPERATION B0020				
0013				<OLD STD> 5.12				
0020				16JAN86 UPDATED OCC FACTORS <OLD STD> 2.84				
0900				N. MONROE MANEAA 73357				

TO INTERROGATE LABOR STANDARDS. INPUT

NR NROP NR  
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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E0468-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC MNPRA

4S1-93-3

84013

STEP	D L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
A024	S	E	JA	EA 1	J 88335	1.00	PERCENT ENGR 99.9	CSA TRUN CROSS BOLT	.54		.54	
0001			JA	02	00	1.00		PART NUMBER/NSN	.000	.000	.000	0
								4G13347-101A				
								5306004541547				
0055			JA	01	15	1.00		RECENTER PIN--60--	.472	.071	.543	100
0010	E				RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE 2 PARTS	.49962		.287	
0020	E				RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW	BOTH SIDES	.09095		.209	
0030	E				KML-CD-P1	2.00	CENTER DRILL		.01519		.034	
0050	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000			JA	01	00	.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0010							9 JUNE 88 INITIAL INPUT MRPII					
0900							NED MONROE	HANEL 73255 MR BIG				

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC MNPRA

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84013

TECH S S W F PF A/R REV

T K #R A FA SUPPORT

OCC

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DESCRIPTION

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BASE  
HOURS

PFD  
TIME

STD  
HOURS

A  
DLY PCT C

STEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

RA025	S	E	JA	EA	1	J	88335	.08	PERCENT ENGR 99.9	CSA APEX BOLT	.54		.04	
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0
			0010						4G13537-101A	1620001164433				
0045			JA	01	15			1.00		RECENTER PIN--60--	.472	.071	.543	100
			0010	E			RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE 2 PARTS	.49962		.287	
			0020	E			RLA-HP-C3	2.00	CHUCK SYNETH PART IN 4 JAW	BOTH SIDES	.09095		.209	
			0030	E			KML-CD-P1	2.00	CENTER DRILL		.01519		.034	
			0050	E			RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000			JA	01	00			.00		LABOR STANDARD HISTORY	.000	.000	.000	0
			0010						9 JUNE 88 INITIAL INPUT NRPII					
			0900						NED MONROE	HANEL	73255		NR BIG	

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

04/17/89

A-50463-MM1-DY-M45 PAGE 0001

17575A CEA M13 4611020-107A

RCC MNPRA

451-93-3

84013

OPER TECH S B A F PF A/R REV

STEP	D L	T K	#R	A FA	SUPPORT	000	DESCRIPTION	EASE	REF	STD	A
STEP	D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	PLY FOT C
RA026	S	E	JA	EA 1	J 88173	.63 PERCENT ENGR 99.9	COLLAR LOCK COLLAR C-5A	1.44		.91	
0001			JA	01	00	.00	PART NUMBER/NS:	.000	.000	.000	0
0010						4611447-101A	1620001157359				
0050			JA	01	15	1.00	NICK & BLUR	.055	.008	.064	4
0010 E					RLG-BS-N4	1.00	NICK & BLUR SMALL STRUT PART	.04595		.052	
0030 E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0052			JA	01	15	.05	O/S ATT LLS LEFT SIDE	.349	.003	.050	1
0010 E					REW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669		.053	
0020 E					RLG-HP-V7	1.00	OBJ IN/OUT STP VISE--ST HAND	.06831		.078	
0030 E					REW-BU-R2	3.00	REAM WITH LEMPOO REAMER	.07337		.253	
0040 E					REW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.004	
0050 E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0054			JA	01	15	.05	O/S ATT LLS RIGHT SIDE	.349	.003	.050	1
0010 E					REW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669		.053	
0020 E					RLG-HP-V7	1.00	OBJ IN/OUT STP VISE--ST HAND	.06831		.078	
0030 E					REW-BU-R2	3.00	REAM WITH LEMPOO REAMER	.07337		.253	
0040 E					REW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.004	
0050 E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0128			JA	01	15	1.00	MACH ATT LLS BUSH LS	.289	.043	.332	23
0010 E					RLA-BU-S3	.25	SET UP SMALL MEDIUM LATHE	.49962		.143	
0020 E					RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.01006		.023	
0030 E					KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250 2 BUSHINGS	.06699		.154	
0040 E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0138			JA	01	15	1.00	INSTL ATT LLS RS	.295	.044	.339	23
0010 E					REW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669		.053	
0020 E					REW-BU-S1	1.00	REBUSH A SET OF 2 BOSSES	.23835		.174	
0030 E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0138			JA	01	15	1.00	MACH ATT LLS RS	.289	.043	.332	23
0010 E					RLA-BU-S3	.25	SET UP SMALL MEDIUM LATHE	.49962		.143	
0020 E					RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.01006		.023	
0030 E					KML-TA-CC	2.00	DIA .501-1.00 REM .033-.250 2 BUSHINGS	.06699		.154	
0040 E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0140			JA	01	15	1.00	INSTL ATT LLS RS	.295	.044	.339	23
0010 E					REW-BU-S1	.25	SET UP TO REBUSH BOSSES	.18669		.053	
0020 E					REW-BU-S1	1.00	REBUSH A SET OF 2 BOSSES	.23835		.174	
0030 E					RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
9000			JA	01	00	.01	LABOR STANDARD HISTORY	.000	.000	.000	0
0001							INITIAL INPUT				
0900							KIM VINCENT, MANEL. 73952				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD WROP NR

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-5046B-MM1-DY-445

PAGE 0001

17575A CSA HLG 4611020-107A

SCC MNPRA

451-93-3

84013

CH S S W F PF A/R REV

T K #R A FA SUPPORT

CCC

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DESCRIPTION

BASE

PF0

STD

A

STEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

RA030	E	N	JA	EA	1	J	89026	.41	PERCENT ENGR	6.0	MACH LOCK RING ASSY	3.54		1.45	
0001			JA	01	00			.00			PART NUMBER / NSN	.000	.000	.000	0
0010									4612636-101A	1620001157427					
0010			JA	01	00			.37			MATCH UP	1.793	.000	.664	19
0010 E								.50	S/U FOR BENCH WORK GENERAL			.27525		.137	
0020 N								1.00			MATCH COMPONENT PARTS	1.50800		1.508	
0030 E								3.00	NICK & BURS SMALL STRUT PARTS			.04595		.137	
0040 E								1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.010	
0025			JA	01	00			.37			PREASSY CLEANING	3.147	.000	1.165	33
0010 E								.50	S/U FOR BENCH WORK GENERAL			.27525		.137	
0020 N								3.00			CLEAN ALL PARTS	1.00000		3.000	
0030 E								1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.010	
0030			JA	01	00			.37			ASSEMBLE COMPONENT PARTS	4.646	.000	1.719	48
0010 E								.50	S/U FOR BENCH WORK GENERAL			.27525		.137	
0020 N								3.00			ASSEMBLE 3 PARTS	1.33300		3.999	
0030 N								1.00			DRILL NEW HOLES	.50000		.500	
0040 E								1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.010	
0000			JA	01	15			.01			LABOR STD HISTORY	.000	.000	.000	0
0010									23JUN83	CCC FACTOR CHG AVG 3 STUDIES					
0020										PREVIOUS STD HRS 0.54					

TO INTERCATE LABOR STANDARDS, INPUT

SCC PRD NROP NR

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TECH S S W F FF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	PAGE HOURS	FFD TIME	STD HOURS	A DLY FCT C
RA034	S	E	JA	EA 1	J 83062	.06	PERCENT ENGR 99.9	ANCHOR SHAFT C-5A	2.99		.17	
0001			JA	01	00	.00	PART NUMBER/NSN		.000	.000	.000	9
0010							4810366-101A 1620002284716LE					
X40			JA	01	15	.68	O/S PIN -OLE	-040-	1.027	.105	.804	27
0010	E				RLA-BU-B3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020	E				RLA-FF-B4	1.00	IRREG PART IN 4 JAW CHUCK	000-BLTP ENDS	.02097		.511	
0030	E				RLA-MM-T2	1.00	INSTALL & ADJUST TOOL NCK BAR		.02970		.074	
0040	E				RLA-MM-F1	1.00	CHANGE FEED		.00326		.003	
0050	E				RLA-MM-S1	1.00	CHANGE SPEED ONE LEVER		.00154		.001	
0060	E				RLA-TA-CA	1.00	DIA .501-1.00 REMOVE (.003)		.04177		.048	
0070	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0080			JA	01	15	.68	O/S THREADED HOLE	-050-	.243	.015	.190	5
0010	E				REW-BU-B1	.50	B/L FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.158	
0020	E				REB-UP-03	1.00	PREP HAND DRILL FOR USE		.00861		.009	
0030	E				SPR-TP-08	1.00	DRILL HOLE WITH HAND DRILL		.00650		.007	
0040	E				PLY-IF-D1	5.00	REMOVE BSK FITTING	000-DIFFICULT REMOVAL	.01197		.068	
0050	E				RNE-NS-04	1.00	PROD TIME NCK BUR SMALL PART		.02100		.024	
0060	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0080			JA	01	15	.83	INST PIN HOLE BUSH	-060-	.724	.090	.652	20
0010	E				RLA-BU-B3	.75	SET UP SMALL MEDIUM LATHE		.49962		.470	
0020	E				KML-TD-BA	1.00	DIA .251-.500 (.033)	FLANGE	.06193		.071	
0030	E				KML-TD-BA	1.00	DIA .251-.500 (.033)	OD	.06193		.071	
0040	E				RLA-FF-B3	1.00	FACE FINISH 1/2 - 1 GROUP 4		.03356		.038	
0050	E				RLA-BG-AG	1.00	BORE HOLE ( 1/2 DIA 1 IN DP		.10123		.116	
0060	E				RLA-CO-AG	1.00	CUT OFF ( 1/2 DIA. GROUP 4		.03108		.035	
0070	E				RLA-FR-B3	1.00	FACE ROUGH 1/2 - 1 DIA GRP 4		.01648		.018	
0080	E				RLA-FF-B3	1.00	FACE FINISH 1/2 - 1 GROUP 4		.03356		.038	
0110	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0080			JA	01	15	.83	INST PIN HOLE BUSH	-060-	.724	.090	.652	20
0070	E				REW-BU-B1	.75	SET UP TO REBUSH BOSSES		.18669		.161	
0100	E				REW-BU-B1	.75	REBUSH A SET OF 2 BOSSES		.23835		.205	
0110	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0070			JA	01	15	.63	INSTALL INSERT	-070-	1.043	.170	.598	22
0010	E				RLA-BU-B3	.75	SET UP SMALL MEDIUM LATHE		.49962		.470	
0020	E				KML-TD-BA	1.00	DIA .251-.500 (.033)	FLANGE	.06193		.071	
0030	E				KML-TD-BA	1.00	DIA .251-.500 (.033)	OD	.06193		.071	
0040	E				RLA-FF-B3	1.00	FACE FINISH 1/2 - 1 GROUP 4		.03356		.038	
0050	E				RLA-BG-AG	1.00	BORE HOLE ( 1/2 DIA 1 IN DP		.10123		.116	
0060	E				RLA-CO-AG	1.00	CUT OFF ( 1/2 DIA. GROUP 4		.03108		.035	
0070	E				RLA-FR-B3	1.00	FACE ROUGH 1/2 - 1 DIA GRP 4		.01648		.018	
0080	E				RLA-FF-B3	1.00	FACE FINISH 1/2 - 1 GROUP 4		.03356		.038	
0090	E				REW-BU-B1	.75	SET UP TO REBUSH BOSSES		.18669		.161	
0100	E				REW-BU-B1	.75	REBUSH A SET OF 2 BOSSES		.23835		.205	
0110	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0120							F.COLLINS TECHN MANEPA					
0000			JA	01	15	.01	LABOR STD HISTORY		.000	.000	.000	9
0010							23JUN83 CHG CCC FACTORS					
0020							PREVIOUS STD HRS .08 3/3/83					

TO INTERROGATE LABOR STANDARDS, INPUT

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/16/89

A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC MNPRA

4S1-93-3

84013

CH S S W F PF A/R REV

T K #R A FA SUPPORT OCC

STEP D L K C DC ELEMENT FACT

DESCRIPTION

STORED

SUPPLEMENTAL

BASE  
HOURS

PF  
TIME

STD  
HOURS

A  
DLY PCT C

0000	S	E	JA	EA	1	J	89018	.09	PERCENT ENGR 99.9	C-5A ROUND NUT	4.70		.42		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									4G13782-101A	5310004970602					
0040			JA	01	15			.68		MACH NEW SLOTS	3.285	.335	2.569		55
0010	E					KHM-SU-V1		.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS		.50518		.145		
0020	E					RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E					RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E					RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E					RML-BD-AC		8.00	BORE HOLE 1 X 1 1/2 GROUP 4USE PROPER ELEMENT/TABLE		.35762		3.290		
0060	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0045			JA	01	15			1.00		MACH REPAIR OLD SLOTS	1.855	.278	2.133		45
0010	E					KHM-SU-V1		.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS		.50518		.145		
0020	E					RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
0030	E					RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
0040	E					RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
0050	E					RML-BD-AC		4.00	BORE HOLE 1 X 1 1/2 GROUP 4USE PROPER ELEMENT/TABLE		.35762		1.645		
0060	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
9000			JA	01	15			.01		LABOR STD HISTORY	.000	.000	.000		0
0010									23JUN83 OCC FACTOR CHG AVG 3 STUDIES						
0020									PREVIOUS STD HRS 0.01						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/16/89

A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC NMRA

4S1-93-3

84013

TECH S S W F PF A/R REV									
T K #R A FA SUPPORT		OCC	DESCRIPTION			BASE	PFD	STD	A
STEP D L	K C DC ELEMENT	FACT	STORED	SUPPLEMENTAL		HOURS	TIME	HOURS	DLY PCT C
RA041	S E JA EA 1	J 88337	.05	PERCENT ENGR 99.9	CSA THRUST BEARING	.87		.04	
0001	JA 01 00		.05		PART NUMBER/NSN	.000	.000	.000	0
0010				4G19074-101A	3120005426972				
0025	JA 01 15		1.00		MACH TO REQ'D THICKNESS--10-	.757	.114	.871	100
0010 E	RLA-SU-S3		1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020 E	RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCKMACHINE 2 SIDES		.01006		.023	
0030 E	RLA-FR-LG		2.00	FACE ROUGH 7 - 8 DIA. GRP 4 OCC FOR 11 IN DIA		.03779		.086	
0040 E	RLA-FF-LG		2.00	FACE FINISH 7 - 8 GROUP 4 OCC FOR 11 IN DIA		.07619		.175	
0050 E	RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000	JA 01 00		.00		LABOR STANDARD HISTORY	.000	.000	.000	0
0010				9 JUNE 88 INITIAL INPUT MRPII					
0900				NED MONROE MANEL 73255 MR BIG					

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/16/89

A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC MNPRA

4S1-93-3

84013

CH S S W F PF A/R REV										OCC <----->		DESCRIPTION		BASE		PFD		STD		A			
T K #R A FA SUPPORT										OCC		DESCRIPTION		BASE		PFD		STD		A			
STEP D L K C DC ELEMENT FACT										FACT		STORED		SUPPLEMENTAL		HOURS		TIME		HOURS		DLY PCT C	
A043	S	E	JA	EA	1	J	88319	.09	PERCENT ENGR 99.9				HACH PISTON STOP TUBE C-5A			1.10				.09			
0001			JA	00	00			.00					PART NUMBER/NSW			.000	.000			.000		0	
0010									4612409-101B				1620001299168										
0079			JA	01	15			1.00					TURN BUSHING GROUP 4/STEEL			.747	.112			.860		77	
0010	E					RLA-SU-S3		1.00	SET UP SMALL MEDIUM LATHE				PRORATE OVER 4 PARTS			.49962				.574			
0020	E					RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK							.01006				.023			
0030	E					KML-TD-CC		2.00	DIA .501-1.00 REM .033-.250							.10898				.250			
0040	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC							.01001				.011			
0080			JA	01	15			1.00					INST STRAIGHT BUSH NO POLISH			.217	.033			.250		23	
0010	E					RBW-BU-S1		1.00	SET UP TO REBUSH BOSSES				PRORATE OVER 4 PARTS			.18669				.214			
0020	E					RBW-BU-A4		1.00	INSTALL ONE STRAIGHT BUSHING							.00000				.023			
0030	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC							.01001				.011			
9000			JA	01	00			.00					LABOR STANDARD HISTORY			.000	.000			.000		0	
0010									9 JUNE 88 INITIAL INPUT MRPII														
0900									NED MONROE				MANEL										
													73255										
													MR BIG										

TO INTERPRETE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/16/89

A-3046B-MM1-BY-M45 PAGE 0001

17575A CSA MLG 4611020-107A

RCC MNRA

451-93-3

84013

TECH S S W F PF A/R REV

T K #R A FA SUPPORT

JSEP D L K C DC ELEMENT

OCC &lt;----- DESCRIPTION -----&gt;

FACT

STORED

SUPPLEMENTAL

BASE  
HOURSPFD  
TIMESTD  
HOURSA  
DLY PCT C

RA048	S	E	JA	EA	1	J	88334	1.00	PERCENT ENGR 99.9	CSA FLUID TRS HOUSING	3.07		3.07		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
									4612583-103A	1620001157419					
0055			JA	01	15			.20		NICK AND BURR SMALL PART	.055	.002	.013		0
	0010	E				RLG-RS-N4		1.00	NICK & BURR SMALL STRUT PART		.04595		.052		
	0030	E				RJP-PW-R1		1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0060			JA	01	15			.40		O/S HOLE ON MILL/SMALL PART	.604	.036	.278		9
	0010	E				KHM-SU-V1		.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS		.50518		.145		
	0020	E				RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
	0030	E				RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
	0040	E				RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
	0050	E				RML-BA-AA		1.00	BORE HOLE 1 X 1/2 GROUP 1 USE PROPER ELEMENT/TABLE		.17936		.206		
	0060	E				RJP-PW-R1		1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0065			JA	01	15			.40		O/S HOLE ON MILL/SMALL PART	.604	.036	.278		9
	0010	E				KHM-SU-V1		.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS		.50518		.145		
	0020	E				RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
	0030	E				RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
	0040	E				RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
	0050	E				RML-BA-AA		1.00	BORE HOLE 1 X 1/2 GROUP 1 USE PROPER ELEMENT/TABLE		.17936		.206		
	0060	E				RJP-PW-R1		1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0070			JA	01	15			.30		O/S HOLE ON MILL/SMALL PART	.640	.029	.221		7
	0010	E				KHM-SU-V1		.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS		.50518		.145		
	0020	E				RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
	0030	E				RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
	0040	E				RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
	0050	E				RML-BA-CD		1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE		.21626		.248		
	0060	E				RJP-PW-R1		1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0075			JA	01	15			.20		O/S HOLE ON MILL/SMALL PART	.480	.014	.110		4
	0010	E				KHM-SU-V1		.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS		.50518		.145		
	0020	E				RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
	0030	E				RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
	0040	E				RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
	0050	E				KML-TA-CA		1.00	DIA .501-1.00 REN .033 KMLTACA		.05535		.063		
	0060	E				RJP-PW-R1		1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0120			JA	01	15			.30		O/S HOLE ON MILL/SMALL PART	.640	.029	.221		7
	0010	E				KHM-SU-V1		.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS		.50518		.145		
	0020	E				RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098		
	0030	E				RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146		
	0040	E				RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087		
	0050	E				RML-BA-CD		1.00	BORE HOLE 2 X 2 GROUP 1 FLAME SPRAY		.21626		.248		
	0060	E				RJP-PW-R1		1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0124			JA	01	15			.40		TURN BUSHING GROUP 1/BRONZE	.289	.017	.133		4
	0010	E				RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS		.49962		.143		
	0020	E				RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
	0030	E				KML-TA-CC		2.00	DIA .501-1.00 REN .033-.250 2 BUSHINGS		.06699		.154		
	0040	E				RJP-PW-R1		1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0125			JA	01	15			.40		INST/REAM SET STRAIGHT BUSH	.167	.010	.077		3
	0010	E				RBW-BU-S1		.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS		.18669		.053		
	0020	E				RBW-BU-B2		.50	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH		.22231		.127		
	0030	E				RJP-PW-R1		1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0129			JA	01	15			.40		TURN BUSHING GROUP 1/BRONZE	.289	.017	.133		4
	0010	E				RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS		.49962		.143		
	0020	E				RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
	0030	E				KML-TA-CC		2.00	DIA .501-1.00 REN .033-.250 2 BUSHINGS		.06699		.154		
	0040	E				RJP-PW-R1		1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		

0130	JA 01	15	.40	INST/REAM SET STRAIGHT BUSH	.278	.017	.128	4
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.22231		.255	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	.10	REPLACE LEE PLUGS-113 & 115-	.508	.008	.058	2
0010 E		RDR-SU-R1	.50 S/U TO O/S BOSSES RAD DRILL	2 AREAS	.56378		.324	
0020 E		RLA-DR-CB	2.00 DRILL HOLE 1/8-1/4 DIA. X 1	REMOVE PLUGS	.04660		.107	
0030 E		RDR-SU-S1	1.00 CHANGE TOOL IN RADIAL DRILL		.00722		.008	
0040 E		RLA-DR-CB	2.00 DRILL HOLE 1/8-1/4 DIA. X 1	O/S PLUG HOLES	.04660		.107	
0050 E		RBW-BU-A2	1.00 INSTALL SET STRAIGHT BUSHING	OR LEE PLUGS	.02299		.026	
0060 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0145	JA 01	15	.20	INST SET FLANGED BUSHINGS	.082	.002	.019	1
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	.50 INSTALL SET FLANGED BUSHINGS	NO POLISH	.05133		.029	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0150	JA 01	15	.25	INSTALL HELICOILS --125--	.293	.011	.084	3
0010 E		RBW-SU-G1	1.00 S/U FOR BENCH WORK GENERAL		.27525		.316	
0020 E		GLM-AS-AA	2.00 INSTALL HELICAL SPRING	2EA	.00432		.009	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0900				LARRY CLARK-TECHN-MANEAA				
0155	JA 01	15	1.00	INST SET FLANGED BUSHINGS	.082	.012	.095	3
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	.50 INSTALL SET FLANGED BUSHINGS	NO POLISH	.05133		.029	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0158	JA 01	15	.20	TURN BUSHING GROUP 4/STEEL	.611	.018	.141	5
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	4.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.046	
0030 E		KHL-TD-CC	4.00 DIA .501-1.00 REM .033-.250		.10898		.501	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	1.00	INST/REAM SET STRAIGHT BUSH	.945	.142	1.088	35
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B2	4.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.22231		1.022	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000	JA 01	00	.00	LABOR STANDRD HISTORY	.000	.000	.000	0
0900				8 APR. 1988 RICHARD G. MARTIN MANEL-73357-MRP11				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

04/17/89  
481-93-3

A-E046B-MMI-DY-145 PAGE 0001  
84013

17575A CEA MLS 4811020-107A

RCC MRPRA

OPER TECH S S W F PF A/R REV

STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE -DURS	PRD TIME	STD HOURS	A DLY PCT C
RAC51	S	E	JA	EA	1	J 89012	.79	PERCENT ENGR 99.9	MACH C-5A M BALLSCREW PIN		.54		.42	
0001			JA	01	00		.00		PART VDYSER/NSN		.000	.000	.000	0
0010								431360E-103A	5315001481779					
0040			JA	01	1E		1.00		RECENTER PIN--60--		.472	.071	.540	100
0010	E					RLA-SU-B3	.50	SET UP SMALL MEDIUM LATHE	PROGRATE 2 PARTS		.49982		.157	
0020	E					RLA-PP-03	2.00	CHUCK SWET PART IN 4 JAW	BOTH SIDES		.09093		.119	
0030	E					WHL-03-F1	2.00	CENTER DRILL			.01519		.024	
0050	E					RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC			.01001		.011	
0000			JA	01	00		.00		LABOR STANDARD HISTORY		.000	.000	.000	0
0010								9 JUNE 88 INITIAL INPUT MRP11						
0900								NEO MONROE	MANEL 70155 MR 519					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC RAD MRP11

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/16/89

A-E0468-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC MNPRA

4S1-93-3

84013

S W F PF A/R REV

STEP		T	K	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
D L		K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT C
A091	S	N	JA	EA	1	J	88351	.15	PERCENT ENGR 59.2	MACH SWIVEL FITTING(STEPED)	3.41		.51
0001			JA	01	00		1.00		PART NUMBER/NSN	.000	.000	.000	0
0010							4612586-101A	1620001157398					
0040			JA	01	15		.72		END HOLE REPAIR	.211	.023	.176	5
0010	E				RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E				RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011		
0030	E				KML-TA-CC	1.00	DIA .501-1.00 REM .033-.250		.06699		.077		
0040	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0045			JA	01	00		.87		REPAIR THREADED END	.271	.000	.236	7
0010	E				RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 2 PARTS	.49962		.249		
0020	E				KML-CD-DD	1.00	CUT OFF 1.5-2 DIA ADD 1/8 INCUT OFF END		.00418		.004		
0030	E				KML-FF-DH	1.00	FACE FINISH 1.5 TO 2 ADD 1/8		.00743		.007		
0040	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
0050			JA	01	15		.87		DRILL HOLES IN FITTING	.297	.039	.298	9
0010	E				RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE		.49962		.143		
0020	E				KML-CD-P1	3.00	CENTER DRILL	DRILL 3 HOLES	.01519		.052		
0030	E				RLA-DR-CA	3.00	DRILL HOLE 1/8-1/4 DIA ( 1/2		.03903		.134		
0040	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0060			JA	01	00		.87		MFG A STUD (INSERT)	1.634	.000	1.422	42
0010	E				RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE		.49962		.124		
0020	N					1.00		MANUFACTURE STUD	.66700		.667		
0030	N					1.00		THREAD STUD BOTH ENDS	.83300		.833		
0040	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
0060			JA	01	15		1.00		MACH END HOLE BUSHINGS	.373	.056	.429	13
0010	E				RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E				RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
0030	E				KML-TD-CC	2.00	DIA .501-1.00 REM .033-.250		.10898		.250		
0040	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090			JA	01	15		1.00		INST END HOLE BUSHINGS	.295	.044	.339	10
0010	E				RBW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E				RBW-BU-B1	1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0095			JA	01	15		.87		INSTALL INSERT	.348	.045	.349	10
0010	E				RBW-SU-H1	1.00	SET UP TO INSTALL HELICOILS		.31093		.357		
0020	E				RBW-TR-H1	1.00	INSTALL HELICOIL INSERT		.02763		.031		
0030	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0100			JA	01	00		1.00		CHASE THREADED END	.161	.000	.162	5
0010	E				RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.137		
0020	E				GTL-TH-A1	1.00	TAP HOLE TO 0.25 IN THRD DIA		.01427		.014		
0030	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.010		
9000			JA	01	15		.01		LABOR STD HISTORY	.000	.000	.000	0
0010							23JUN83 OCC FACTOR CHG AVG 3 STUDIES						
0020							PREVIOUS STD HRS 0.43						

IF INTERROGATE LABOR STANDARDS. INPUT

TOP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/16/89

A-E046B-MM1-DY-H45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC MNPRA

4S1-93-3

84013

TECH S S W F PF A/R REV

T K #R A FA SUPPORT

STEP D L K C DC ELEMENT

OCC

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE

HOURS

PFD

TIME

STD

HOURS

DLY

PCT

A

C

RA092	S	N	JA	EA	1	J	88351	.05	PERCENT ENGR 59.2	MACH SWIVEL FITTING (LARGE)	3.41		.17		
0001			JA	01	00			1.00		PART NUMBER/NSN	.000	.000	.000		0
0010									4612584-101A	1620001157396					
0040			JA	01	15			.72		END HOLE REPAIR	.211	.023	.176		5
0010 E						RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020 E						RLA-HP-C1		1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011		
0030 E						KML-TA-CC		1.00	DIA .501-1.00 REM .033-.250		.06699		.077		
0040 E						RJP-PW-R1		1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0045			JA	01	00			.87		REPAIR THREADED END	.271	.000	.236		7
0010 E						RLA-SU-S3		.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 2 PARTS	.49962		.249		
0020 E						KML-CD-DD		1.00	CUT OFF 1.5-2 DIA ADD 1/8 INCUT OFF END		.00418		.004		
0030 E						KML-FF-DH		1.00	FACE FINISH 1.5 TO 2 ADD 1/8		.00743		.007		
0040 E						RJP-PW-R1		1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.010		
0050			JA	01	15			.87		DRILL HOLES IN FITTING	.297	.039	.298		9
0010 E						RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE		.49962		.143		
0020 E						KML-CD-P1		3.00	CENTER DRILL	DRILL 3 HOLES	.01519		.052		
0030 E						RLA-DR-CA		3.00	DRILL HOLE 1/8-1/4 DIA ( 1/2		.03903		.134		
0040 E						RJP-PW-R1		1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0060			JA	01	00			.87		MFG A STUD (INSERT)	1.634	.000	1.422		42
0010 E						RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE		.49962		.124		
0020 N								1.00		MANUFACTURE STUD	.66700		.667		
0030 N								1.00		THREAD STUD BOTH ENDS	.83300		.833		
0040 E						RJP-PW-R1		1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.010		
0045			JA	01	15			1.00		MACH END HOLE BUSHINGS	.373	.056	.429		13
0010 E						RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020 E						RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
0030 E						KML-TD-CC		2.00	DIA .501-1.00 REM .033-.250		.10898		.250		
0040 E						RJP-PW-R1		1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0090			JA	01	15			1.00		INST END HOLE BUSHINGS	.295	.044	.339		10
0010 E						RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020 E						RBW-BU-B1		1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030 E						RJP-PW-R1		1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0095			JA	01	15			.87		INSTALL INSERT	.348	.045	.349		10
0010 E						RBW-SU-H1		1.00	SET UP TO INSTALL HELICOILS		.31093		.357		
0020 E						RBW-TR-H1		1.00	INSTALL HELICOIL INSERT		.02763		.031		
0030 E						RJP-PW-R1		1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0100			JA	01	00			1.00		CHASE THREADED END	.161	.000	.162		5
0010 E						RBW-SU-G1		.50	S/W FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.137		
0020 E						GTL-TH-A1		1.00	TAP HOLE TO 0.25 IN THRD DIA		.01427		.014		
0030 E						RJP-PW-R1		1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.010		
9000			JA	01	15			1.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0900									C. W. RIGBY MANEL-1	73357					

TO INTERROGATE LABOR STANDARDS. INPUT

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/16/89

A-E046B-MH1-DY-M45 PAGE 0001

17575A CSA MLG 4611020-107A

RCC MNFRA

451-93-3

84013

CH S S W F PF A/R REV

T K #R A FA SUPPORT

OCC <----- DESCRIPTION ----->

BASE PFD STD A

STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C

0A093	S	N	JA	EA	1	J	88351	.15	PERCENT ENGR 59.2	MACH SWIVEL FITTING (INT)	3.41		.51		
0001			JA	01	00			1.00		PART NUMBER/NSN	.000	.000	.000		0
									4612585-101A	1620001157397					
0040			JA	01	15			.72		END HOLE REPAIR	.211	.023	.176		5
0010	E					RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E					RLA-HP-C1		1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011		
0030	E					KML-TA-CC		1.00	DIA .501-1.00 REM .033-.250		.06699		.077		
0040	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0045			JA	01	00			.87		REPAIR THREADED END	.271	.000	.236		7
0010	E					RLA-SU-S3		.50	SET UP SMALL MEDIUM LATHE	PRORATE OVER 2 PARTS	.49962		.249		
0020	E					KML-CD-DD		1.00	CUT OFF 1.5-2 DIA ADD 1/8 INCUT OFF END		.00418		.004		
0030	E					KML-FF-DH		1.00	FACE FINISH 1.5 TO 2 ADD 1/8		.00743		.007		
0040	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.010		
0050			JA	01	15			.87		DRILL HOLES IN FITTING	.297	.039	.298		9
0010	E					RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE		.49962		.143		
0020	E					KML-CD-P1		3.00	CENTER DRILL	DRILL 3 HOLES	.01519		.052		
0030	E					RLA-DR-CA		3.00	DRILL HOLE 1/8-1/4 DIA ( 1/2		.03903		.134		
0040	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0060			JA	01	00			.87		MFG A STUD (INSERT)	1.634	.000	1.422		42
0010	E					RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE		.49962		.124		
0020	N							1.00		MANUFACTURE STUD	.66700		.667		
30	N							1.00		THREAD STUD BOTH ENDS	.83300		.833		
40	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.010		
0085			JA	01	15			1.00		MACH END HOLE BUSHINGS	.373	.056	.429		13
0010	E					RLA-SU-S3		.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E					RLA-HP-C1		2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS		.01006		.023		
0030	E					KML-TD-CC		2.00	DIA .501-1.00 REM .033-.250		.10898		.250		
0040	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0090			JA	01	15			1.00		INST END HOLE BUSHINGS	.295	.044	.339		10
0010	E					RBW-BU-S1		.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E					RBW-BU-B1		1.00	REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.23835		.274		
0030	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0095			JA	01	15			.87		INSTALL INSERT	.348	.045	.349		10
0010	E					RBW-SU-H1		1.00	SET UP TO INSTALL HELICOILS		.31093		.357		
0020	E					RBW-TR-H1		1.00	INSTALL HELICOIL INSERT		.02763		.031		
0030	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011		
0100			JA	01	00			1.00		CHASE THREADED END	.161	.000	.162		5
0010	E					RBW-SU-G1		.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.137		
0020	E					GTL-TH-A1		1.00	TAP HOLE TO 0.25 IN THRD DIA		.01427		.014		
0030	E					RJP-PW-R1		1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.010		
9000			JA	01	15			.01		LABOR STD HISTORY	.000	.000	.000		0
0010									23JUN83 OCC FACTOR CHG AVG 3 STUDIES						
0020									PREVIOUS STD HRS 0.43						

INTERROGATE LABOR STANDARDS. INPUT

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/16/89

A-E046B-HM1-DY-M45 PAGE 0001

17575A CSA HLG 4611020-107A

RCC MNPRA

4S1-93-3

84013

CH S S W F PF A/R REV T K #R A FA SUPPORT STEP D L K C DC ELEMENT										OCC FACT	DESCRIPTION STORED		SUPPLEMENTAL		BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
0057	E	N	JA	EA 1	J 84316	1.00	PERCENT ENGR	.0	REPAIR GUAGE P/N 3714	411	1.15			1.15				
0001			JA	00	60	.00			PART NUMBER/NSN		.000	.000		.000			0	
0010							G3714		6685002283784									
0020							4694407-101A											
0020			JA	01	15	1.00			REMOVE LENS		.500	.075		.575			50	
0010	N					1.00			REMOVE LENS		.50000			.575				
0050			JA	01	15	1.00			INSTALL LENS		.500	.075		.575			50	
0010	N					1.00			INSTALL LENS		.50000			.575				
9000			JA	01	00	.00			LABOR STANDARD HISTORY		.000	.000		.000			0	
0010							9 JUNE 88	INITIAL	INPUT MRPII									
0990							NED MONROE	HANEL	73255	MR BIG								

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP MR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E0448-HM1-DY-H45 PAGE 0001

17575A CSA HLG 4G11020-107A

RCC HMPRB

451-93-3

84013

H S S W F P F A/R REV

STEP	D L	K C	DC	ELEMENT	OCC FACT	STOR	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
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0001	S	E	JA	EA 3	J 87092	.79	PERCENT ENGR 98.0	GRIND OUTER CYLINDER	502	29.28	23.13	
0001			JA	01 00		.00		PART NUMBER/NSN		.000	.000	0
0010							4G11415-107A	1620004463776				
0020			JA	01 15		1.00		CK AREA C TO DIA B		1.180	.177	5
0010 E					RGR-SU-I2	.25	SET UP LRG INTERNAL GRINDER	PRORATE OVER 4 OPERATION		1.53372	.440	
0020 E					RLA-HP-C3	.25	CHUCK SYMET PART IN 4 JAW	PRD RATE 4 OPER		.09095	.026	
0030 E					RLA-HP-C4	.25	IRREG PART IN 4 JAW CHUCK	PRORATE/4 OPERATIONS		.22097	.063	
0040 E					RGR-HP-L3	.25	LOAD EX LRG PRT GAP GR FIXT	PRORATE/4 OPERATIONS		.36081	.103	
0050 E					KMG-GW-LK	4.00		LOCATE INDICATOR/4 TIMES		.06761	.311	
0060 E					KMH-SU-A1	4.00	DIAL ONE AXIS LONG OR CROSS	4 PLACES		.03892	.179	
0070 E					RJP-PW-C1	32.00	WRITE CRITICAL DIMENSION	32 READINGS		.00601	.221	
0080 E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001	.011	
0025			JA	01 15		1.00		CK DIA C TO COLLAR AREA		.716	.107	3
0010 E					RGR-SU-I2	.25	SET UP LRG INTERNAL GRINDER	PRORATE/4 OPERATIONS		1.53372	.440	
0020 E					RLA-HP-C3	.25	CHUCK SYMET PART IN 4 JAW	PRD RATE 4 OPER		.09095	.026	
0030 E					RLA-HP-C4	.25	IRREG PART IN 4 JAW CHUCK	PRORATE/4 OPERATIONS		.22097	.063	
0040 E					RGR-HP-L3	.25	LOAD EX LRG PRT GAP GR FIXT	PRORATE/4 OPERATIONS		.36081	.103	
0050 E					KMG-GW-LK	1.00		LOCATE INDICATOR		.06761	.077	
0060 E					KMH-SU-A1	1.00	DIAL ONE AXIS LONG OR CROSS	1 PLACE		.03892	.044	
0070 E					RJP-PW-C1	8.00	WRITE CRITICAL DIMENSION	8 READINGS		.00601	.055	
0080 E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001	.011	
			JA	01 15		1.00		CHK UPPER BORE TO DIA A		1.025	.154	4
0010 E					RGR-SU-I2	.25	SET UP LRG INTERNAL GRINDER	PRORATE/4 OPERATIONS		1.53372	.440	
0020 E					RLA-HP-C3	.25	CHUCK SYMET PART IN 4 JAW	PRD RATE 4 OPER		.09095	.026	
0030 E					RLA-HP-C4	.25	IRREG PART IN 4 JAW CHUCK	PRORATE/4 OPERATIONS		.22097	.063	
0040 E					RGR-HP-L3	.25	LOAD EX LRG PRT GAP GR FIXT	PRORATE/4 OPERATIONS		.36081	.103	
0050 E					KMG-GW-LK	3.00		LOCATE IDICATOR/3 PLACES		.06761	.233	
0060 E					KMH-SU-A1	3.00	DIAL ONE AXIS LONG OR CROSS	3 PLACES		.03892	.134	
0070 E					RJP-PW-C1	24.00	WRITE CRITICAL DIMENSION	24 READINGS		.00601	.165	
0080 E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001	.011	
0035			JA	01 15		1.00		CHK LOWER BORE TO DIA A		1.025	.154	4
0010 E					RGR-SU-I2	.25	SET UP LRG INTERNAL GRINDER	PRORATE/4 OPERATIONS		1.53372	.440	
0020 E					RLA-HP-C3	.25	CHUCK SYMET PART IN 4 JAW	PRD RATE 4 OPER		.09095	.026	
0030 E					RLA-HP-C4	.25	IRREG PART IN 4 JAW CHUCK	PRORATE/4 OPERATIONS		.22097	.063	
0040 E					RGR-HP-L3	.25	LOAD EX LRG PRT GAP GR FIXT	PRORATE/4 OPERATIONS		.36081	.103	
0050 E					KMG-GW-LK	3.00		LOCATE INDICATOR/3 PLACES		.06761	.233	
0060 E					KMH-SU-A1	3.00	DIAL ONE AXIS LONG OR CROSS	3 PLACES		.03892	.134	
0070 E					RJP-PW-C1	24.00	WRITE CRITICAL DIMENSION	24 READINGS		.00601	.165	
0080 E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001	.011	
0050			JA	01 15		.11		GRIND CHAMFER AREA C		2.044	.034	1
0010 E					RGR-SU-P1	1.00	SET UP PLANETARY GRINDER			.82175	.945	
0020 E					RHL-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMP			.15776	.181	
0030 E					RHL-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609	.087	
0040 E					RHL-AL-AA	1.00	ALIGN HORIZ AXIS ROD			.06265	.072	
0050 E					RHL-AL-AB	1.00	ALIGN VERTICAL AXIS ROD			.12699	.146	
0060 E					KMG-DW-MW	.50	DRESS OR FORM NEW WHEEL	PRORATE 2 PARTS		.06761	.038	
0070 E					KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761	.077	
0080 E					KMG-OD-DE	1.00	GRIND .010 DIA X 3 LONG			.68818	.791	
0090 E					RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC,			.01001	.011	
0085			JA	01 15		.32		1ST GRIND O.D.		9.497	.456	12
0010 E					RGR-SU-G1	1.00	SET UP A GAP GRINDER			1.05938	1.218	
0020 E					RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW	LOAD CENTER 1 DIAL IN		.09095	.104	
0030 E					RGR-HP-L2	2.00	LOAD EXTRA LRG PRT GAP GRINDROCE DUE TO EXTREME SIZE			.16231	.373	
0040 E					RGR-GE-S2650.00	GR STEEL OD (OCC FACT L X D) 52.0 X 12.5				.01093	8.170	
0050 E					RGR-GF-D2	12.50	DWELL (GAP GRINDER STEEL OD) 12.5 DIA			.01014	.145	

0060 E	RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0070 E	RGR-WD-G2	3.00	WHEEL DRESS GAP GRINDER	OCC DUE TO EXTREME SIZE	.08334		.287	
0080 E	RGR-HM-C5	1.50	HANDLE & MEAS LENGTH 24 - 36	OCC FOR 52 INCH LENGTH	.11700		.201	
0090 E	RLG-RS-F4	78.00	FILE/GRIND & POL NICK/BURR	OCC FOR 37.5 IN CIRCUMFERENC	.00415		.372	
			UPPER & LOWER END OF CYL					
0095 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0100 E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION		.00601		.006	
0090	JA 01	15	.16	1ST GRIND UPPER BORE	10.741	.258	1.977	7
0010 E	RGR-SU-I2	1.00	SET UP LRG INTERNAL GRINDER		1.53372		1.763	
0020 E	RGR-HP-L4	2.00	LOAD LARGE PART GAP GR FIXTRLOAD PART INTERNAL GRINDER		.30830		.709	
0022			OCC FOR EXTREME SIZE OF PART					
0030 E	RML-AL-AC	4.00	ALIGN HOLE TO SPINDLE ROD	OCC FOR EXTREME SIZE	.07609		.350	
0040 E	KMG-ID-TE	5.33	GRIND OUT .010 12 ID X 3	OCC FOR 005 TO 007 MATERIAL	1.46961		9.007	
0042			REMOVAL 32 INCH LONG 32/3 X .5=5.33					
0050 E	KMG-DW-ID	3.00	DRESS INTERNAL WHEEL	OCC FOR EXTREME SIZE	.02458		.084	
0060 E	RTL-SU-G1	3.00	SET UP A DIAL BORE GAGE	OCC FOR EXTREME LENGTH &	.08248		.284	
0062			DIA 32 INCHES LONG X 12 INCHES					
0070 E	RGR-HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36	USE BORE GAGE TO CHECK PART	.11700		.134	
0080 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0085 E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION		.00601		.006	
0100	JA 01	15	.05	1ST GRIND LOWER BORE	3.718	.028	.214	1
0010 E	RGR-SU-I2	1.00	SET UP LRG INTERNAL GRINDER		1.53372		1.763	
0020 E	RGR-HP-L4	2.00	LOAD LARGE PART GAP GR FIXTRLOAD LARGE PART INT GRINDER		.30830		.709	
0022			OCC FOR EXTREME SIZE OF PART					
0030 E	RML-AL-AC	4.00	ALIGN HOLE TO SPINDLE ROD	OCC FOR EXTREME SIZE	.07609		.350	
0040 E	KMG-ID-TB	1.67	GRIND OUT .010 12.0 ID X 1.0	OCC FOR 005 TO 007 MATERIAL	.56064		1.076	
0042			REMOVAL 10 INCH LONG 10/3 X .5=1.67					
0050 E	KMG-DW-ID	2.00	DRESS INTERNAL WHEEL	OCC FOR EXTREME SIZE	.02458		.056	
0060 E	RTL-SU-G1	2.00	SET UP A DIAL BORE GAGE	OCC FOR EXTREME SIZE	.08248		.189	
0070 E	RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12	USE BORE GAGE TO CHECK I.D.	.09717		.111	
0080 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0085 E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION		.00601		.006	
0105	JA 01	15	.16	1ST GRIND COLLAR I.D.	3.675	.088	.676	2
0010 E	RGR-SU-I2	1.00	SET UP LRG INTERNAL GRINDER		1.53372		1.763	
0020 E	RGR-HP-L2	2.00	LOAD EXTRA LRG PRT GAP GRINDROCC DUE TO EXTREME SIZE		.16231		.373	
0030 E	RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE ROD	OCC FOR EXTREME SIZE	.07609		.175	
0040 E	KMG-ID-QD	2.00	GRIND OUT .010 8.0 ID X 2.0	4 INCHES LONG	.67681		1.556	
0042			4.0 X 7.80					
0050 E	KMG-DW-ID	2.00	DRESS INTERNAL WHEEL	1 TO SQ WHEEL 1 FOR FINISH	.02458		.056	
0060 E	RTL-SU-G1	2.00	SET UP A DIAL BORE GAGE	OCC FOR EXTREME SIZE	.08248		.189	
0070 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5	USE BORE GAGE TO CHECK I.D.	.08102		.093	
0075 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0080 E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION		.00601		.006	
0110	JA 01	15	.11	HONE LOWER BORE	3.394	.056	.429	1
0010 E	RTL-UD-C1	1.00	CHANGE TOOL UNIVERSAL DRIVER		.00623		.007	
0020 E	RMD-HP-L1	2.00	LOAD UNLOAD HONE WITH HOIST	OCC FOR EXTREME SIZE	.17802		.409	
0030 N		1.00	HONE ID		3.00000		3.450	
0032			FINISH & SIZE NO SUPPORT ELEMENTS AVAILABLE					
0034			AT THIS TIME					
0035 E	RLG-EI-C7	3.00	HONE ID THREE TIMES		.00534		.018	
0040 E	RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0050 E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION		.00601		.006	
0113	JA 01	15	.11	LOCAL POLISH ON	.540	.009	.068	0
0010 E	RLM-SU-G1	.25	S/U FOR BENCH WORK GENERAL	PRORATE OVER 4 PARTS	.27325		.079	
0020 E	RTL-SU-G1	1.00	SET UP A DIAL BORE GAGE		.08248		.094	
0030 E	RTL-HM-H1	1.00	HONE ID OR 2 FLAT SURFACES		.00481		.005	
0040 E	ZPO-BP-C4	1.00	BUTTERFLY POLISH V/LRG CYL		.30517		.350	
0050 E	ZIT-VI-B4	1.00	VISUAL INSP V/LRG CYL I.D.		.07328		.084	
0060 E	RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC		.00601		.006	
0115	JA 01	15	.05	HONE UPPER BORE	3.394	.025	.195	1
0010 E	RTL-UD-C1	1.00	CHANGE TOOL UNIVERSAL DRIVER		.00623		.007	
0020 E	RMD-HP-L1	2.00	LOAD UNLOAD HONE WITH HOIST	OCC FOR EXTREME SIZE	.17802		.409	

0030 N		1.00	HONE ID	3.00000	3.450			
0032			FINISH & SIZE NO SUPPORT ELEMENTS AVAILABLE					
0034			AT THIS TIME					
0035 E		RLG-EI-C7	3.00	NIKE ID THREE TIMES	.00534	.018		
0036 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001	.011		
0037 E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	.00601	.006		
0118	JA 01	15	.11	LOCAL POLISH ID	.540	.009	.068	0
0010 E		RBW-SU-G1	.25	S/U FOR BENCH WORK GENERAL PRORATE OVER 4 PARTS	.27525		.079	
0020 E		RTL-SU-G1	1.00	SET UP A DIAL BORE GAGE	.08248		.094	
0030 E		RTL-MM-H1	1.00	NIKE ID DR 2 FLAT SURFACES	.08481		.005	
0040 E		ZPD-BP-C4	1.00	BUTTERFLY POLISH V/LRG CYL	.30517		.350	
0050 E		ZIT-VI-B4	1.00	VISUAL INSP V/LRG CYL I.D.	.07328		.084	
0060 E		RJP-PW-F1	1.00	SIGN OFF WORK CONTROL DOC	.00601		.006	
0305	JA 01	15	.32	FINISH GRIND O.D.	16.884	.810	6.214	21
0010 E		RGR-SU-G1	1.00	SET UP A GAP GRINDER	1.05938		1.218	
0020 E		RLA-HP-C3	1.00	CHUCK SYNET PART IN 4 JAW LOAD CENTER & DIAL IN	.09095		.104	
0030 E		RGR-HP-L2	2.00	LOAD EXTRA LRG PRT GAP GRINDROCC DUE TO EXTREME SIZE	.14231		.373	
0040 E		RGR-GE-C2650.00		GR CHROM OD (OCC FACT L X D) 52.0 X 12.5	.02189		16.362	
0050 E		RGR-GE-D3	12.50	DWELL (GAP GRINDER CHROM OD) 12.5 DIA	.02029		.291	
0060 E		RGR-HM-T2	3.00	ADJUST TAPER - GAP GRINDER OCC DUE TO EXTREME SIZE	.02632		.090	
0070 E		RGR-WD-G2	4.00	WHEEL DRESS GAP GRINDER OCC DUE TO EXTREME SIZE	.08334		.383	
0080 E		RGR-HM-C5	1.50	HANDLE & MEAS LENGTH 24 - 36OCC FOR 52 INCH LENGTH	.11700		.201	
0090 E		RLG-RS-F4	78.00	FILE/GRIND & POL NICK/WRR OCC FOR 37.5 IN CIRCUMFERENC	.08415		.372	
0092				UPPER & LOWER END OF CYL				
0095 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0100 E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	.00601		.006	
0330	JA 01	15	.11	FINISH GRIND UPPER BORE	17.508	.289	2.215	8
0010 E		RGR-SU-I2	1.00	SET UP LRG INTERNAL GRINDER	1.53372		1.763	
0020 E		RGR-HP-L4	2.00	LOAD LARGE PART GAP GR FIXTRLOAD INTERNAL OCC FOR SIZE	.30830		.709	
0030 E		RML-AL-AC	2.00	ALIGN HOLE TO SPINDLE END OCC FOR EXTREME SIZE	.07609		.175	
0040 E		KMG-ID-TK	5.33	GRIND OUT .040 12 ID X 3 OCC FOR 015 TO 020 MATERIAL	2.78772		17.087	
0042				REMOVAL 32 INCH LONG 32/3 X .5=5.33				
0050 E		KMG-DW-ID	2.00	DRESS INTERNAL WHEEL 1 TO SQ WHEEL 1 FOR FINISH	.02458		.056	
0060 E		RTL-SU-G1	2.00	SET UP A DIAL BORE GAGE OCC FOR EXTREME SIZE OF BORE	.08248		.189	
0070 E		RGR-HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36USE BORE GAGE TO CHECK I.D.	.11700		.134	
0080 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0085 E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	.00601		.006	
0335	JA 01	15	.21	FINISH GRIND LOWER BORE	7.486	.236	1.808	6
0010 E		RGR-SU-I2	1.00	SET UP LRG INTERNAL GRINDER	1.53372		1.763	
0020 E		RGR-HP-L4	2.00	LOAD LARGE PART GAP GR FIXTRLOAD PART IN INT GRINDER	.30830		.709	
0022				OCC FOR EXTREME SIZE				
0030 E		RML-AL-AC	4.00	ALIGN HOLE TO SPINDLE END OCC FOR EXTREME SIZE	.07609		.350	
0040 E		KMG-ID-TK	1.67	GRIND OUT .040 12 ID X 3 OCC FOR 015 TO 025 MATERIAL	2.78772		5.353	
0042				REMOVAL 10 INCH LONG 10/3 X .5=1.67				
0050 E		KMG-DW-ID	4.00	DRESS INTERNAL WHEEL 1 TO SQ WHEEL 2 FOR ROUGH	.02458		.113	
0052				GRIND & 1 FOR FINISH				
0060 E		RTL-SU-G1	2.00	SET UP A DIAL BORE GAGE OCC FOR EXTREME SIZE	.08248		.189	
0070 E		RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12USE DIAL BORE GAGE CHECK PT	.09717		.111	
0080 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0085 E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	.00601		.006	
0340	JA 01	15	.05	HONE LOWER BORE	.628	.005	.036	0
0010 E		RTL-UD-C1	1.00	CHANGE TOOL UNIVERSAL DRIVER	.00623		.007	
0020 E		RHO-HP-L1	2.00	LOAD UNLOAD HONE WITH MIST OCC FOR EXTREME SIZE	.17802		.409	
0030 H			.08	HONE UPPER & LOWER BORE FOR	3.00000		.276	
0032				FINISH & SIZE NO SUPPORT ELEMENTS AVAILABLE AT THIS TIME				
0035 E		RLG-EI-C7	3.00	NIKE ID THREE TIMES	.00534		.018	
0040 E		RJP-PW-R1	1.00	REN RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0345	JA 01	15	.05	HONE UPPER BORE	.628	.005	.036	0
0010 E		RTL-UD-C1	1.00	CHANGE TOOL UNIVERSAL DRIVER	.00623		.007	
0020 E		RHO-HP-L1	2.00	LOAD UNLOAD HONE WITH MIST OCC FOR EXTREME SIZE	.17802		.409	
0030 N			.08	HONE UPPER & LOWER BORE FOR	3.00000		.276	

FINISH & SIZE NO SUPPORT ELEMENTS AVAILABLE AT THIS TIME									
0032									
0034									
0035 E	RLG-EI-C7	3.00		MIKE ID THREE TIMES		.00534		.018	
7 E	RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC			.01001		.011	
JA 01	15	.37		FINISH GRIND COLLAR I.D.	3.846	.213	1.637		6
0010 E	RGR-SU-P1	1.00	SET UP PLANETARY GRINDER			.82175		.945	
0020 E	RGR-HP-L4	2.00	LOAD LARGE PART GAP GR FIXTRLOAD PART IN PLANETARY			.30830		.709	
0022			OCC FOR EXTREME SIZE						
0030 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD			.07609		.087	
0040 E	KMG-ID-QJ	1.50	GRIND OUT .040 8 ID X 2 4 INCHES LONG OCC FOR 020		1.37361		2.369		
0042			TO 025 MTL REMOVAL						
0050 E	KMG-DW-ID	4.00	DRESS INTERNAL WHEEL 1 TO SQ WHEEL TO PART 2 FOR		.02458		.113		
0052			ROUGH & 1 FOR FINISH GRIND						
0060 E	RTL-SU-G1	1.00	SET UP A DIAL BORE GAGE		.08248		.094		
0070 E	RGR-HH-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5 USE DIAL BORE GAGE CHECK I.D		.08102		.093		
0090 E	RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011		
0430	JA 01	15	.53	FINISH GRIND COLLAR BUSHING	2.795	.222	1.704		6
0010 E	RGR-SU-P1	1.00	SET UP PLANETARY GRINDER		.82175		.945		
0020 E	RGR-HP-L2	2.00	LOAD EXTRA LRG PRT GAP GRNDRLOAD PART IN PLANETARY OCC		.16231		.373		
0022			FOR EXTREME SIZE						
0030 E	RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083		
0040 E	KMG-ID-QD	2.00	GRIND OUT .010 8.0 ID X 2.0 OCC FOR 4 INCH LENGTH		.67681		1.556		
0042			4.0 X 7.8						
0050 E	KMG-DW-ID	2.00	DRESS INTERNAL WHEEL 1 TO SQ WHEEL TO PART 1 FOR		.02458		.056		
0052			FINISH						
0060 E	RTL-SU-G1	1.00	SET UP A DIAL BORE GAGE		.08248		.094		
0070 E	RGR-HH-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5 USE BORE GAGE CHECK I.D.		.08102		.093		
0090 E	RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011		
JA 01	15	1.00		CK AREA C TO DIA B	1.180	.177	1.357		5
0 E	RGR-SU-I2	.25	SET UP LRG INTERNAL GRINDER PRORATE OVER 4 OPERATION		1.53372		.440		
0020 E	RLA-HP-C3	.25	CHUCK SYMET PART IN 4 JAW PRO RATE 4 OPER		.09095		.026		
0030 E	RLA-HP-C4	.25	IRREG PART IN 4 JAW CHUCK PRORATE/4 OPERATIONS		.22097		.063		
0040 E	RGR-HP-L3	.25	LOAD EX LRG PRT GAP GR FIXT PRORATE/4 OPERATIONS		.36081		.103		
0050 E	KMG-GW-LK	4.00	LOCATE INDICATOR/4 TIMES		.06761		.311		
0060 E	KMH-SU-A1	4.00	DIAL ONE AXIS LONG OR CROSS 4 PLACES		.03892		.179		
0070 E	RJP-PW-C1	32.00	WRITE CRITICAL DIMENSION 32 READINGS		.00601		.221		
0080 E	RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011		
0440	JA 01	15	1.00	CHK UPPER BORE TO DIA A	1.025	.154	1.179		4
0010 E	RGR-SU-I2	.25	SET UP LRG INTERNAL GRINDER PRORATE/4 OPERATIONS		1.53372		.440		
0020 E	RLA-HP-C3	.25	CHUCK SYMET PART IN 4 JAW PRO RATE 4 OPER		.09095		.026		
0030 E	RLA-HP-C4	.25	IRREG PART IN 4 JAW CHUCK PRORATE/4 OPERATIONS		.22097		.063		
0040 E	RGR-HP-L3	.25	LOAD EX LRG PRT GAP GR FIXT PRORATE/4 OPERATIONS		.36081		.103		
0050 E	KMG-GW-LK	3.00	LOCATE INDICATOR/3 PLACES		.06761		.233		
0060 E	KMH-SU-A1	3.00	DIAL ONE AXIS LONG OR CROSS 3 PLACES		.03892		.134		
0070 E	RJP-PW-C1	24.00	WRITE CRITICAL DIMENSION 24 READINGS		.00601		.165		
0080 E	RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011		
0445	JA 01	15	1.00	CHK LOWER BORE TO DIA A	1.025	.154	1.179		4
0010 E	RGR-SU-I2	.25	SET UP LRG INTERNAL GRINDER PRORATE/4 OPERATIONS		1.53372		.440		
0020 E	RLA-HP-C3	.25	CHUCK SYMET PART IN 4 JAW PRO RATE 4 OPER		.09095		.026		
0030 E	RLA-HP-C4	.25	IRREG PART IN 4 JAW CHUCK PRORATE/4 OPERATIONS		.22097		.063		
0040 E	RGR-HP-L3	.25	LOAD EX LRG PRT GAP GR FIXT PRORATE/4 OPERATIONS		.36081		.103		
0050 E	KMG-GW-LK	3.00	LOCATE INDICATOR/3 PLACES		.06761		.233		
0060 E	KMH-SU-A1	3.00	DIAL ONE AXIS LONG OR CROSS 3 PLACES		.03892		.134		
0070 E	RJP-PW-C1	24.00	WRITE CRITICAL DIMENSION 24 READINGS		.00601		.165		
0080 E	RJP-PW-R1	1.00	REN RPL PAPMARK SIGN OFF DOC		.01001		.011		
JA 01	15	.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0010				30MAY85 UPDATED OCCURRENCE FACTORS/WORK PREVIOUSLY					
0011				DONE ON OPER A0010 <OLD STD> 19.57					
0012				AND OPER A0270 <OLD STD> 8.00					
0020				29JAN86 UPDATED OCC FACTORS <OLD STD> 30.13					
0030				21APR87 RESTRUCTURED LABOR STANDARD TO MATCH NEW					
0071				AFLC FORM 958: NO TIME CHANGE					

## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-HM1-DY-M45 PAGE 0001

17575A CSA MLG 4611020-107A

RCC MNPRD

451-93-3

84013

CH S S W F PF A/R REV

T K #R A FA SUPPORT

STEP D L K C DC ELEMENT

OCC

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE

HOURS

PFD

TIME

STB

HOURS

A

DLY PCT C

RB002	S	E	JA	EA	3	J	84030	.67	PERCENT ENGR 88.2	GRIND INNER CYLINDER C-5A	23.19		15.53		
0001			JA	01	00			1.00		PART NUMBER/NSN	.000	.000	.000		0
0010									4611414-107A	1620004176249					
0130			JA	01	15			.63		1ST GRIND CYL O.D.	7.242	.684	5.247		23
0010	E							1.00	SET UP A GAP GRINDER		1.05938		1.218		
0020	E							2.00	LOAD EX LRG PRT GAP GR FIXT OCC FOR EXTREME SIZE		.36081		.829		
0030	E							3.00	CHUCK SYNTH PART IN 4 JAW DIAL IN/EXTREME SIZE		.09095		.313		
0040	E							6.00	GR STEEL OD (OCC FACT L X D) 36 LENGTH X 11 DIAMETER		.01093		4.977		
0050	E							11.00	DWELL (GAP GRINDER STEEL OD) 11 DIAMETER		.01014		.128		
0060	E							3.00	WHEEL DRESS GAP GRINDER 3 PER OPERATION		.08334		.287		
0070	E							3.00	ADJUST TAPER - GAP GRINDER 3 PER OPERATION		.02632		.090		
0080	E							1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134		
0090	E							69.00	FILE/GRIND & POL NICK/BURR CIRCUMFERENCE BOTH ENDS		.00415		.329		
0095	E							1.00	WRITE CRITICAL DIMENSION		.00601		.006		
0100	E							1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0140			JA	01	15			.07		1ST GRIND UP BRNG O.D.	3.425	.036	.276		1
0010	E							1.00	SET UP A GAP GRINDER		1.05938		1.218		
0020	E							2.00	LOAD EX LRG PRT GAP GR FIXT OCC FOR EXTREME SIZE		.36081		.829		
0030	E							2.00	CHUCK SYNTH PART IN 4 JAW DIAL IN/EXTREME SIZE		.09095		.209		
0040	E							77.00	GR STEEL OD (OCC FACT L X D) 7 LENGTH X 11 DIAMETER		.01093		.967		
0050	E							11.00	DWELL (GAP GRINDER STEEL OD) 11 DIAMETER		.01014		.128		
0060	E							1.00	WHEEL DRESS GAP GRINDER		.08334		.095		
0070	E							1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0080	E							1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111		
0090	E							69.00	FILE/GRIND & POL NICK/BURR CIRCUMFERENCE BOTH ENDS		.00415		.329		
0095	E							1.00	WRITE CRITICAL DIMENSION		.00601		.006		
0100	E							1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0150			JA	01	15			.07		HONE I.D. TO CLEAN UP	2.691	.028	.217		1
0010	E							1.00	SET UP LARGE VERTICAL HONE		.55195		.634		
0020	E							1.00	LOAD UNLOAD HONE WITH HOIST		.17802		.204		
0030	N							1.00		HONE I.D.	1.65000		1.897		
0040	E							1.00	SET UP A DIAL BORE GAGE		.08248		.094		
0050	E							2.00	HANDLE & MEAS LENGTH 12 - 24 MEASURE TWICE		.10674		.245		
0060	E							1.00	WRITE CRITICAL DIMENSION		.00601		.006		
0070	E							1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0160			JA	01	15			.19		GRIND I.D. STANDARD	12.423	.354	2.714		12
0010	E							1.00	SET UP LRG INTERNAL GRINDER		1.53372		1.763		
0020	E							2.00	LOAD EX LRG PRT GAP GR FIXT LOAD PART IN INTERNAL GRINDER/OCC FOR EXTREME SIZE		.36081		.829		
0022															
0030	E							2.00	CHUCK SYNTH PART IN 4 JAW DIAL IN AXIS/OCCURANCE FOR EXTREME SIZE		.09095		.209		
0032															
0040	E							8.00	GRIND OUT .010 ID X 3 OCC FOR 47.0 IN. LONG X 11.0 DIA .005-.008 MATERIAL REMOVAL		1.19745		11.016		
0042															
0050	E							3.00	DRESS INTERNAL WHEEL 3 TIMES PER OPERATION		.02458		.084		
0060	E							1.00	SET UP A DIAL BORE GAGE		.08248		.094		
0070	E							2.00	HANDLE & MEAS LENGTH 24 - 36 47 IN/3 TIMES/3 PLACES		.11700		.269		
0075	E							1.00	WRITE CRITICAL DIMENSION		.00601		.006		
0080	E							1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
			JA	01	15			.05		HONE CYL I.D.	2.591	.019	.149		1
0010	E							1.00	SET UP LARGE VERTICAL HONE		.55195		.634		
0020	E							1.00	LOAD UNLOAD HONE WITH HOIST		.17802		.204		
0030	N							1.00		HONE CYL I.D. TO REMOVE BURN	1.65000		1.897		
0031									INDICATIONS AND MAINTAIN FINISH						
0040	E							1.00	SET UP A DIAL BORE GAGE		.08248		.094		
											.10674		.122		

0060 E		RJP-PW-C1	2.00	WRITE CRITICAL DIMENSION	TWO DIMENSIONS	.00601		.013	
0070 E		RJP-PW-R1	1.00	REN RPL PAPPRWK SIGN OFF DOC,		.01001		.011	
0350	JA 01	15	1.00		HONE CYL I.D. AFTER SHOTPEEN	2.591	.389	2.980	13
00 E		RHO-SU-V1	1.00	SET UP LARGE VERTICAL HONE	,	.55195		.634	
00 E		RHO-HP-L1	1.00	LOAD UNLOAD HONE WITH HOIST	,	.17802		.204	
0030 M			1.00		HONE CYL I.D. TO REMOVE BURN	1.65000		1.897	
0031				INDICATIONS AND MAINTAIN FINISH					
0040 E		RTL-SU-G1	1.00	SET UP A DIAL BORE GAGE	,	.08248		.094	
0050 E		RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24,		.10674		.122	
0060 E		RJP-PW-C1	2.00	WRITE CRITICAL DIMENSION	TWO DIMENSIONS	.00601		.013	
0070 E		RJP-PW-R1	1.00	REN RPL PAPPRWK SIGN OFF DOC,		.01001		.011	
0380	JA 01	15	.38		REIDENTIFY	.017	.001	.008	0
0010 E		GID-SA-A1	1.00	STAMP WITH METAL STAMP	,	.00342		.003	
0020 E		GID-SA-A2	2.00	STAMP W/METAL STAMP ADDL	TWO NUMBERS	.00187		.004	
0030 E		RJP-PW-R1	1.00	REN RPL PAPPRWK SIGN OFF DOC,		.01001		.011	
0390	JA 01	15	.63		FINISH GRIND CYL O.D.	11.745	1.110	8.510	37
0010 E		RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218	
0020 E		RGR-HP-L3	2.00	LOAD EX LRG PRT GAP GR FIXT OCC FOR EXTREME SIZE		.36081		.829	
0030 E		RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW	DIAL IN PART OCC FOR EXTREME	.09095		.209	
0032				SIZE					
0040 E		RGR-GE-C2396.00	GR CHROM OD (OCC FACT L X D)36.0 X 11.0			.02189		.9.768	
0050 E		RGR-GE-D3	11.00	DWELL (GAP GRINDER CHROM OD)11.0 IN DIA		.02029		.256	
0060 E		RGR-HM-T2	5.00	ADJUST TAPER - GAP GRINDER	OCC FOR EXTREME SIZE	.02632		.151	
0070 E		RGR-WD-G2	4.00	WHEEL DRESS GAP GRINDER	OCC FOR EXTREME SIZE	.08334		.383	
0080 E		RGR-HM-C5	1.00	HANDLE & MEAS LENGTH 24 - 36		.11700		.134	
0090 E		GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILL		.00678		.007	
0100 E		RLG-RS-F4	69.00	FILE/GRIND & POL NICK/BURR	USE AIR MOTOR & FLAPWHEEL TO	.00415		.329	
0102				BREAK EDGES & BLEND RADIOUS OCC/CIRCUM EA END					
005 E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	,	.00601		.006	
00 E		RJP-PW-R1	1.00	REN RPL PAPPRWK SIGN OFF DOC		.01001		.011	
0400	JA 01	15	.13		FINISH GRIND UP BEARING	4.637	.090	.693	3
0010 E		RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218	
0020 E		RGR-HP-L3	2.00	LOAD EX LRG PRT GAP GR FIXT OCC FOR EXTREME SIZE		.36081		.829	
0030 E		RLA-HP-C3	2.00	CHUCK SYMET PART IN 4 JAW	DIAL IN AXIS OCC FOR EXTREME	.09095		.209	
0032				SIZE					
0040 E		RGR-GE-C2	77.00	GR CHROM OD (OCC FACT L X D)7.0 X 11.0		.02189		1.938	
0050 E		RGR-GE-D3	11.00	DWELL (GAP GRINDER CHROM OD)11.0 IN DIA		.02029		.256	
0060 E		RGR-WD-G2	4.00	WHEEL DRESS GAP GRINDER	1 TO SQ WHEEL TO PART 2 FOR	.08334		.383	
0062				ROUGH & 1 FOR FINISH GRIND					
0070 E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0080 E		RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111	
0090 E		GTL-EP-A2	1.00	SET UP & DISMANTLE AIR DRILL		.00678		.007	
0100 E		RLG-RS-F4	69.00	FILE/GRIND & POL NICK/BURR	USE AIR MOTOR & FLAP WHEEL 0	.00415		.329	
0102				FLASHON TO BREAK EDGES & BLEND RADIOUS OCC/INCH					
0104				OF CIRCUMFERENCE UPPER & LOWER END OF BRG SFC					
0105 E		RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	,	.00601		.006	
0110 E		RJP-PW-R1	1.00	REN RPL PAPPRWK SIGN OFF DOC		.01001		.011	
0410	JA 01	15	1.00		INSPECT I.D.	.023	.004	.027	0
0010 E		GIT-HP-A3	1.00	VISUAL INSPECT WITH LIGHT		.00143		.001	
0015 E		RJP-PW-C1	2.00	WRITE CRITICAL DIMENSION	TWO DIMENSIONS	.00601		.013	
0020 E		RJP-PW-R1	1.00	REN RPL PAPPRWK SIGN OFF DOC		.01001		.011	
0420	JA 01	15	.32		HONE CYL I.D.	2.591	.124	.954	4
0010 E		RHO-SU-V1	1.00	SET UP LARGE VERTICAL HONE	,	.55195		.634	
0020 E		RHO-HP-L1	1.00	LOAD UNLOAD HONE WITH HOIST	,	.17802		.204	
00 E			1.00		HONE CYL I.D. TO REMOVE BURN	1.65000		1.897	
01				INDICATIONS AND MAINTAIN FINISH					
0040 E		RTL-SU-G1	1.00	SET UP A DIAL BORE GAGE	,	.08248		.094	
0050 E		RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24,		.10674		.122	
0060 E		RJP-PW-C1	2.00	WRITE CRITICAL DIMENSION	TWO DIMENSIONS	.00601		.013	
0070 E		RJP-PW-R1	1.00	REN RPL PAPPRWK SIGN OFF DOC,		.01001		.011	
0520	JA 01	15	.69		FIN GRIND METER PIN BUSH	1.785	.185	1.416	6
0010 E		RGR-SU-R1	1.00	SET UP PLANETARY GRINDER					

0020 E	RGR-HP-L2	2.00	LOAD EXTRA LRG PRT GAP GRNDRLOAD PART IN PLANETARY GR	.16231	.373	
0022			OCC FOR EXTREME SIZE			
0030 E	RML-AL-CC	2.00	ALIGN HOLE TO SPINDLE MAG BSOC FOR EXTREME SIZE	.07261	.167	
0031 E	KMG-ID-KB	1.00	GRIND OUT .010-4.5 IN ID X 1	.20899	.240	
0032 E	KMG-DW-ID	2.00	DRESS INTERNAL WHEEL 1 TO SQ WHEEL 1 FOR FINISH	.02458	.056	
0040 E	RTL-SU-G1	1.00	SET UP A DIAL BORE GAGE	.08248	.094	
0070 E	RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5 CHECK I.D. 3 PLACES 3 TIMES	.08102	.093	
0080 E	RLG-RS-F4	12.00	FILE/GRIND & POL NICK/BURR BREAK EDGES BLEND RABIOUS	.00415	.057	
0082			OCC FOR EXTREME SIZE			
0085 E	RJP-PW-C1	2.00	WRITE CRITICAL DIMENSION TWO DIMENSIONS	.00601	.013	
0090 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
9000	JA 01	15	.01 LABOR STANDARD HISTORY	.009	.000	.000
0010			30JAN86 RESTRUCTURED LABOR STD TO MATCH AFLC FORM			0
0011			958/UPDATED OCC FACTORS/ADDED SUB OP 0150			
0012			WORK PREVIOUSLY DONE ON OPER A0090			
0013			<OLD STD> 13.63			
0900			N MONROE MANEAM 73357			

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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17575A CSA MLG 4611020-107A

CH S S W F PF A/R REV

T K R A FA SUPPORT

STEP D L K C DC ELEMENT FACT OCC <----- DESCRIPTION -----> BASE PFD STD A  
HOURS TIME HOURS DLY PCT C

RB005	S	E	JA	EA	3	J	89012	.17	PERCENT ENGR 99.9	GRD UPR DRAG SHAFT	3.77		.64		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									4613538-101A	1620001164434					
0060			JA	01	15			1.00		1ST GRIND UPPER DRAG SHAFT	1.346	.202	1.549		41
0010 E							RGR-SU-C2	1.00	SET UP SMALL MED CYL GRINDER D. GRIND		.29197		.335		
0020 E							RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030 E							RLA-HM-T8	1.00	ADVANCE & RETURN TAILSTOCK		.00305		.003		
0040 E							RGR-GE-S2	51.00	GR STEEL OD (OCC FACT L X D) 3 OD X 17 LENGTH		.01093		.641		
0045 E							RGR-GE-D2	3.00	DWELL (GAP GRINDER STEEL OD) 3 OD		.01014		.034		
0050 E							KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL 2 PER OPERATION		.02308		.053		
0060 E							KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION 2 PER OPERATION		.06761		.155		
0070 E							RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122		
0080 E							RLG-RS-F4	18.00	FILE/GRIND & POL NICK/BURR CIRCUMFERENCE BOTH ENDS		.00415		.085		
0100 E							RJP-PW-R1	1.00	REN RPL PAFWRK SIGN OFF DOC		.01001		.011		
0130			JA	01	15			1.00		FINISH GRIND UP DRAG SHAFT	1.936	.290	2.226		59
0010 E							RGR-SU-C2	1.00	SET UP SMALL MED CYL GRINDER D. GRIND		.29197		.335		
0020 E							RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030 E							RLA-HM-T8	1.00	ADVANCE & RETURN TAILSTOCK		.00305		.063		
0040 E							RGR-GE-C2	51.00	GR CHROM OD (OCC FACT L X D) 3 OD X 17 LENGTH		.02189		1.283		
0045 E							RGR-GE-D3	3.00	DWELL (GAP GRINDER CHROM OD) 3 OD		.02029		.070		
0050 E							KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL 2 PER OPERATION		.02308		.053		
0060 E							KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION 2 PER OPERATION		.06761		.155		
0070 E							RGR-HM-C4	1.00	HANDLE & MEAS LENGTH 12 - 24		.10674		.122		
0080 E							RLG-RS-F4	18.00	FILE/GRIND & POL NICK/BURR CIRCUMFERENCE BOTH ENDS		.00415		.085		
0100 E							RJP-PW-R1	1.00	REN RPL PAFWRK SIGN OFF DOC		.01001		.011		
9000			JA	01	15			.01		LABOR STD HISTORY	.000	.000	.000		0
0010									01JUL83 OCC FACTOR CHG AVG 3 STUDIES						
0020									PREVIOUS STD HRS 1.34						
0030									05DEC85 UPDATE OCCURRANCE FACTORS/RESTRUCTURED						
0031									LABOR STANDARD TO MATCH AFLC FORM 958						
0032									OLD OPER NO. A0140 <OLD STD> 1.01						
0900									N MONROE MANEA 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD MROP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-MH1-DY-M45 PAGE 0001

17575A CSA HLG 4611020-107A

RCC MNPRB

451-93-3

84013

SL	STEP	D L	K C	DC	ELEMENT	OCC	FACT	STOR	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
B000					89006	.21	PERCENT ENGR 99.9		GRD LOWER DRAG SHAFT		4.88		1.02	
0001		JA	01	00		1.00			PART NUMBER/NSN		.000	.000	.000	0
0010					4613539-101A				1620001164435					
0060		JA	01	15		1.00			1ST GRIND LOWER SHAFT --60--		1.682	.252	1.934	40
0010 E					RGR-SU-C2	1.00	SET UP SMALL MED CYL GRINDER O.D. GRIND				.29197		.335	
0020 E					RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW				.09095		.104	
0030 E					RLA-HH-T8	1.00	ADVANCE & RETURN TAILSTOCK				.00305		.003	
0040 E					RGR-GE-C2	76.50	GR STEEL OD (OCC FACT L X D) 4.5 OD X 17 LENGTH				.01093		.961	
0045 E					RGR-GE-D2	4.50	DWELL (GAP GRINDER STEEL OD) 4.5 OD				.01014		.052	
0050 E					KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL 2 PER OPERATION				.02308		.053	
0060 E					KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION 2 PER OPERATION				.06761		.155	
0070 E					RGR-HH-C4	1.00	HANDLE & MEAS LENGTH 12 - 24				.10674		.122	
0080 E					RLG-RS-F4	28.00	FILE/GRIND & POL NICK/BURR CIRCUMFERENCE BOTH ENDS				.00415		.133	
0100 E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC				.01001		.011	
0130		JA	01	15		1.00			FINISH GRIND LO SHAFT --130--		2.566	.385	2.951	60
0010 E					RGR-SU-C2	1.00	SET UP SMALL MED CYL GRINDER O.D. GRIND				.29197		.335	
0020 E					RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW				.09095		.104	
0030 E					RLA-HH-T8	1.00	ADVANCE & RETURN TAILSTOCK				.00305		.003	
0040 E					RGR-GE-C2	76.50	GR CHROM OD (OCC FACT L X D) 4.5 OD X 17 LENGTH				.02189		1.925	
0045 E					RGR-GE-D3	4.50	DWELL (GAP GRINDER CHROM OD) 4.5 OD				.02029		.105	
0050 E					KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL 2 PER OPERATION				.02308		.053	
0060 E					KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION 2 PER OPERATION				.06761		.155	
0070 E					RGR-HH-C4	1.00	HANDLE & MEAS LENGTH 12 - 24				.10674		.122	
0080 E					RLG-RS-F4	28.00	FILE/GRIND & POL NICK/BURR CIRCUMFERENCE BOTH ENDS				.00415		.133	
0100 E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC				.01001		.011	
0900							F. COLLINS TECHN MANEAA							
9000		JA	01	15		.01			LABOR STD HISTORY		.000	.000	.000	0
0010							01 JUL 83 OCC FACTOR CHG AVG 3 STUDIES							
0020							PREVIOUS STD HRS 2.65							
0030							28 DEC 85 UPDATE OCCURANCE FACTORS							
0031							RESTUCTURED LABOR STD TO MATCH							
0032							AFLC FORM 958							
0033							WORK PREVIOUSLY DONE ON OPER A0080							
0034							OLD STD WAS 2.12 HRS							
0900							N MONROE MANEAA 73357							

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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17575A CSA NLG 4611020-107A

RCC MNPRB

451-93-3

84013

H S S W F PF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
B007	S	E	JA	EA 3	J 86015	1.00	PERCENT ENGR 99.9	GRIND CSA NLG SPLINED TUBE	1.65		1.65	
0001			JA	01 00		.00	PART NUMBER / NSN		.000	.000	.000	0
0010					4613413-101A		NSL					
0025			JA	01 15		1.00	CHECK SEAL GROOVE/CONCENTRIC		.402	.060	.463	28
0010	E				RGR-SU-C2	.50	SET UP SMALL MED CYL GRINDERPRORATE 2 OPERATIONS		.29197		.167	
0020	E				RLA-HP-C3	.50	CHUCK SYMET PART IN 4 JAW PRORATE 2 OPERATIONS		.09095		.052	
0030	E				RGR-HM-H1	.50	ADJUST HEADSTOCK GAP GRINDERPRORATE 2 OPERATIONS		.08590		.049	
0040	E				RGR-HM-T2	.50	ADJUST TAPER - GAP GRINDER PRORATE 2 OPERATIONS		.02632		.015	
0050	E				RML-AL-CC	2.00	ALIGN HOLE TO SPINDLE MAG BS2 DIAMETERS		.07261		.167	
0060	E				RJP-PW-R1	1.00	REM RPL PAPRMWK SIGN OFF DOC		.01001		.011	
0026			JA	01 15		1.00	CHECK SPLINES		.475	.071	.547	33
0010	E				RGR-SU-C2	.50	SET UP SMALL MED CYL GRINDERPRORATE		.29197		.167	
0020	E				RLA-HP-C3	.50	CHUCK SYMET PART IN 4 JAW PRORATE		.09095		.052	
0030	E				RGR-HM-H1	.50	ADJUST HEADSTOCK GAP GRINDERPRORATE		.08590		.049	
0040	E				RGR-HM-T2	.50	ADJUST TAPER - GAP GRINDER PRORATE		.02632		.015	
0050	E				RML-AL-CC	3.00	ALIGN HOLE TO SPINDLE MAG BS3 DIAMETERS		.07261		.250	
0060	E				RJP-PW-R1	1.00	REM RPL PAPRMWK SIGN OFF DOC		.01001		.011	
0070			JA	01 15		.13	1ST GRIND SEAL GROOVE		1.828	.036	.273	17
0010	E				RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218	
0020	E				RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT		.36081		.414	
0030	E				RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0040	E				RGR-GE-S2	3.25	GR STEEL OD (OCC FACT L X D)		.01093		.040	
0050	E				RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD)		.01014		.069	
0060	E				RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095	
0070	E				RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0080	E				RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111	
0090	E				RLG-RS-F4	1.00	FILE/GRIND & POL NICK/BURR		.00415		.004	
0100	E				RJP-PW-R1	1.00	REM RPL PAPRMWK SIGN OFF DOC		.01001		.011	
0160			JA	01 15		.13	FINISH GRIND SEAL GROOVE		1.864	.036	.279	17
0010	E				RGR-SU-G1	1.00	SET UP A GAP GRINDER		1.05938		1.218	
0020	E				RGR-HP-L3	1.00	LOAD EX LRG PRT GAP GR FIXT		.36081		.414	
0030	E				RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0040	E				RGR-GE-C2	3.25	GR CHRON OD (OCC FACT L X D)		.02189		.081	
0050	E				RGR-GE-D2	6.00	DWELL (GAP GRINDER STEEL OD)		.01014		.069	
0060	E				RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095	
0070	E				RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0080	E				RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12		.09717		.111	
0090	E				RLG-RS-F4	1.00	FILE/GRIND & POL NICK/BURR		.00415		.004	
0100	E				RJP-PW-R1	1.00	REM RPL PAPRMWK SIGN OFF DOC		.01001		.011	
0170			JA	01 15		.63	CHAMFER SEA GROOVE		.129	.012	.094	6
0010	E				RGR-WD-G2	1.00	WHEEL DRESS GAP GRINDER		.08334		.095	
0020	E				KMG-OD-AF	1.00	GRIND .040 FROM 1/20 X 1		.03633		.041	
0030	E				RJP-PW-R1	1.00	REM RPL PAPRMWK SIGN OFF DOC		.01001		.011	
9000			JA	01 15		.01	LABOR STANDARD HISTORY		.000	.000	.000	0
0010							08JUL85 UPDATED OCCURANCE FACTORS/RESTRUCTURED					
0011							LABOR STANDARD TO MATCH AFLC FORM 958					
0012							<OLD STD> 2.54 HRS ON OPER A0120					
0020							15JAN86 UPDATED OCC FACTORS <OLD STD> 1.53					
0030							M MONROE MANEAM 73357					

TO INTERROGATE LABOR STANDARDS, INPUT

TECH S B W F F A/R REV

K A A FA SUPPORT

000

DESCRIPTION

BASE

REF

STD

A

D L K D DO ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

BY POT D

015	S	E	CA	EA	3	J	25019	.20	PERCENT ENGR 99.9	HONE YOKE/4611430-110	501	4.04		.90	
0001			JA	01	00			1.00		PART NUMBER/MSN		.000	.000	.000	0
0010									4611430-113B	1620001753939					
0050			JA	01	15			1.00		HONE CENTER HOLE		2.210	.032	2.542	63
0010	E					RHD-30-W2		1.00	SET UP VERY LARGE HONE			.99152		1.140	
0020	E					RHD-HP-L1		1.00	LOAD UNLOAD HONE WITH HOIST			.17302		.204	
0030	E					RMS-ID-ED		1.00	GRIND OUT .010 ID X 2.0			1.01543		1.167	
0040	E					RLG-SI-07		3.00	MKE 1/D WARE CHK BY MEASRNG CHECK ID 3 TIMES			.00524		.013	
0050	E					RCP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF 000			.01001		.011	
0015			JA	01	15			1.00		HONE CENTER HOLE TO 64 RMS		1.709	.195	1.506	37
0010	E					RHD-30-W2		1.00	SET UP VERY LARGE HONE			.99152		1.140	
0020	E					RHD-HP-L1		1.00	LOAD UNLOAD HONE WITH HOIST			.17302		.204	
0030	E					RMS-ID-ED		1.00	GRIND OUT .010 ID X 1.5			.13033		.145	
0040	E					RCP-PW-R1		1.00	REM RPL PAPERWK SIGN OFF 000			.01001		.011	
9000			JA	01	15			.01		LABOR STANDARD HISTORY		.000	.000	.000	0
0010									170AN65 NEW REQUIREMENT/INITIAL INPUT						
0900									N MONROE/MANEAP						

I INTERROGATE LABOR STANDARDS, INPUT

TECH S B W F F A/R REV

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4611020-107A

RCC MNPB

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TH S S W F PF A/R REV

TK #R A FA SUPPORT

OCC &lt;----- DESCRIPTION -----&gt;

BASE PFD STD A

STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL HOURS TIME HOURS DLY PCT C

RB016	S	E	JA	EA	3	J	89026	.58	PERCENT ENGR 99.9	GRD.POSITIONING COLLAR CSAM	7.95		4.61		
0001			JA	01	00			.00		PART NUMBER / NSN	.000	.000	.000		0
									4G11476-107A	1620005581485					
									4G11476-101B	1620001157415					
0090			JA	01	15			.93		GRIND TOP OF SMALL TEETH	5.872	.819	6.281		79
0010	E						RGR-SU-J1	1.00	S/U JIG GRINDER SML FIXTURE .		.75732		.870		
0020	E						RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS.		.08531		.098		
0030	E						RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS,		.07261		.083		
0040	E						KMG-DW-ID	3.00	DRESS INTERNAL WHEEL	2 ROUGH, 1 FINISH CUT	.02458		.084		
0050	E						KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233		
0060	E						KMG-ID-TD	1.00	GRIND OUT .010 12 ID X 2.0	GRIND TEETH TO REMOVE CORR.	1.01513		1.167		
0070	E						KMG-DW-ID	3.00	DRESS INTERNAL WHEEL	2 ROUGH 1 FINISH CUT	.02458		.084		
0080	E						KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.233		
0090	E						KMG-ID-TD	1.50	GRIND OUT .010 12 ID X 2.0	GRIND SML TEETH LEFT SIDE	1.01513		1.751		
0091									OCCURRANCED FOR DEPTH						
0100	E						RLG-EI-C3	2.00	CHK FACE TO FACE I/S OR O/S	2 MEASURMENTS REQUIRED	.01427		.032		
0110	E						KMG-DW-ID	3.00	DRESS INTERNAL WHEEL	2 ROUGH, 1 FINISH CUT	.02458		.084		
0120	E						KMG-GW-LK	3.00	LOCATE WHEEL TO POSITION	AFTER EACH DRESS	.06761		.233		
0130	E						KMG-ID-TD	1.50	GRIND OUT .010 12 ID X 2.0	GRIND SML TEETH RIGHT SIDE	1.01513		1.751		
0131									OCCURRANCED FOR DEPTH						
0140	E						RLG-EI-C3	2.00	CHK FACE TO FACE I/S OR O/S	2 MEASURMENTS REQUIRED	.01427		.032		
0150	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC.		.01001		.011		
			JA	01	15			.86		CHAMFER LARGE TEETH	.356	.046	.352		4
0010	E						RBW-SU-G1	.50	S/U FOR BENCH WORK GENERAL	PRORATE 2 PARTS	.27525		.158		
0020	E						RBW-BU-C1	2.00		CHAMFER 2 TEETH	.10435		.240		
0030	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0120			JA	01	15			.14		1ST GRIND COLLAR FACE	1.594	.033	.257		3
0010	E						RGR-SU-I1	1.00	S/U SMALL INTERNAL GRINDER		.49838		.573		
0020	E						RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS.		.08531		.098		
0030	E						KMG-DW-ID	2.00	DRESS INTERNAL WHEEL	1 ROUGH, 1 FINISH GRIND	.02458		.056		
0035	E						KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.155		
0040	E						KMG-ID-TC	1.00	GRIND OUT .010 12 ID X 1.5		.78780		.905		
0050	E						RLG-EI-C3	2.00	CHK FACE TO FACE I/S OR O/S	2 MEASUREMENTS	.01427		.032		
0060	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0130			JA	01	15			.07		1ST GRIND I.D.	2.121	.022	.171		2
0010	E						RGR-SU-I1	1.00	S/U SMALL INTERNAL GRINDER		.49838		.573		
0020	E						RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254		
0030	E						KMG-DW-ID	2.00	DRESS INTERNAL WHEEL	1 ROUGH, 1 FINISH GRIND	.02458		.056		
0035	E						KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.155		
0040	E						KMG-ID-SE	1.00	GRIND OUT .010 10 ID X 3		1.19745		1.377		
0050	E						RLG-EI-C7	2.00	NKE I/D WARE CHK BY MEASRING	2 MEASUREMENTS	.00534		.012		
0060	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0230			JA	01	15			.21		FINISH GRIND FACE	2.590	.082	.626		8
0010	E						RGR-SU-I1	1.00	S/U SMALL INTERNAL GRINDER		.49838		.573		
0020	E						RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS.		.08531		.098		
0030	E						KMG-DW-ID	4.00	DRESS EXTERNAL WHEEL	3 ROUGH, 1 FINISH GRIND	.02308		.106		
0035	E						KMG-GW-LK	4.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.311		
0040	E						KMG-ID-TH	1.00	GRIND OUT .040 12 ID X 1.5		1.60594		1.846		
0050	E						RLG-EI-C3	2.00	CHK FACE TO FACE I/S OR O/S	2 MEASUREMENTS	.01427		.032		
0060	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0240			JA	01	15			.07		FINISH GRIND I.D.	3.380	.035	.272		3
0010	E						RGR-SU-I1	1.00	S/U SMALL INTERNAL GRINDER		.49838		.573		
0020	E						RLA-HP-C4	1.00	IRREG PART IN 4 JAW CHUCK		.22097		.254		
0030	E						KMG-DW-ID	4.00	DRESS INTERNAL WHEEL	3 ROUGH, 1 FINISH GRIND	.02458		.113		
0035	E						KMG-GW-LK	4.00	LOCATE WHEEL TO POSITION	LOCATE AFTER EACH DRESS	.06761		.311		

0040 E	KNG-ID-SK	1.00 GRIND OUT .040 10 ID X3	2.27158	2.612	
0050 E	RLG-EI-C7	2.00 NKE I/D WARE CHK BY MEASUNG 2 MEASUREMENTS	.00534	.012	
0060 E	RJP-PW-R1	1.00 REN RPL PAPRMK SIGN OFF DOC	.01001	.011	
JA 01	15	.01	.000	.000	.000 0

LABOR STANDARD HISTORY

11DEC85 RESTRUCTURED LABOR STD TO MATCH AFLC FORM  
 958/UPDATED OCC FACTOTS/WORK PREVIOUSLY  
 DONE ON OPER A0110 11 9 51D> 2.46  
 N MONROE MANEAM 73357

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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17575A CSA MLG 4611020-107A

W F PF A/R REV

T K #R A FA SUPPORT

STEP D L K C DC ELEMENT

OCC

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE  
HOURS

PFD  
TIME

STD  
HOURS

A  
DLY PCT C

0017	S	E	JA	EA	3	J	88364	.17	PERCENT ENGR	99.9	GRIND APEX SHAFT C-5A	2.06		.35		
0001			JA	00	00			.00			PART NUMBER/NSN	.000	.000	.000		0
0010							4613561-101A				5315001321925					
0060			JA	01	15			1.00			FIRST GRIND O.D.	.772	.116	.888		43
0010	E					RGR-SU-C2	.50	SET UP SMALL MED CYL GRINDER	PRORATE OVER 2 PARTS			.29197		.167		
0020	E					RLA-HP-C6	1.00	LOAD&UNLOAD SHL PART-CENTERS				.02466		.028		
0030	E					RGR-HM-T2	.50	ADJUST TAPER - GAP GRINDER	PRORATE OVER 2 PARTS			.02632		.015		
0040	E					KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL				.02308		.026		
0045	E					KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION				.06761		.077		
0050	E					KMG-OD-FD	2.00	GRIND .010 2 1/2 OD X 2 1/2 OCCURANCE FOR LENGTH				.18000		.414		
0055	E					RGR-GE-D2	3.00	DWELL (GAP GRINDER STEEL OD).				.01014		.034		
0060	E					RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12				.09717		.111		
0070	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC				.01001		.011		
0130			JA	01	15			1.00			FINISH GRIND O.D.	1.022	.153	1.176		57
0010	E					RGR-SU-C2	.50	SET UP SMALL MED CYL GRINDER	PRORATE OVER 2 PARTS			.29197		.167		
0020	E					RLA-HP-C6	1.00	LOAD&UNLOAD SHL PART-CENTERS				.02466		.028		
0030	E					RGR-HM-T2	.50	ADJUST TAPER - GAP GRINDER	PRORATE OVER 2 PARTS			.02632		.015		
0040	E					KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL				.02308		.026		
0045	E					KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION				.06761		.077		
0050	E					KMG-OD-FJ	2.00	GRIND .040 2 1/2 OD X 2 1/2 OCCURANCE FOR LENGTH				.29000		.667		
0055	E					RGR-GE-D3	3.00	DWELL (GAP GRINDER CHROM OD).				.02029		.070		
0060	E					RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12.				.09717		.111		
0070	E					RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC				.01001		.011		
9000			JA	01	15			.01			LABOR STANDARD HISTORY	.000	.000	.000		0
0010							26DEC85		UPDATE OCCURANCE FACTORS/RESTRUCTURED							
0011									LABOR STANDARD TO MATCH AFLC FORM 958							
0012									OLD OPER A0050 <OLD STD> .23							
0900									N MONROE NAMEAA 73357							

TO INTERROGATE LABOR STANDARDS, INPUT

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E0468-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC MNPRB

4S1-93-3

84013

4 S S W F P F A/R REV

T K #R A FA SUPPORT

STEP	D L	K C	DC	ELEMENT	FACT	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
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B018	S	E	JA	EA 3	J 89017	.17 PERCENT ENGR 99.9	GRD RETRACT ARM C-5AM	8.31		1.41	
0001			JA	01	00	.17	PART NUMBER/NSW	.000	.000	.000	0
0010						4G11448-107A	1620001157390				
0100			JA	01	15	1.00	1ST GRIND O.D.	3.041	.456	3.498	42
0010	E					RGR-SU-G1 1.00 SET UP A GAP GRINDER		1.05938		1.218	
0020	E					RLA-HP-C4 1.00 IRREG PART IN 4 JAW CHUCK		.22097		.254	
0040	E					RGR-GE-S2 98.00 GR STEEL OD (OCC FACT L X D) 7 X 14		.01093		1.231	
0050	E					RGR-GE-D2 7.00 DWELL (GAP GRINDER STEEL OD) 7 IN. O.D.		.01014		.081	
0060	E					RGR-WD-G2 2.00 WHEEL DRESS GAP GRINDER 2 PER OPERATION		.08334		.191	
0065	E					KMG-GW-LK 2.00 LOCATE WHEEL TO POSITION 2 PER OPERATION		.06761		.155	
0070	E					RGR-HM-T2 1.00 ADJUST TAPER - GAP GRINDER		.02632		.030	
0080	E					RGR-HM-C4 1.00 HANDLE & MEAS LENGTH 12 - 24		.10674		.122	
0090	E					RLG-RS-F4 42.00 FILE/GRIND & POL NICK/BURR CIRCUMFERENCE OF BOTH ENDS		.00415		.200	
0095						42 SQ INCHES					
0100	E					RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0160			JA	01	15	1.00	2ND GRIND O.D.	4.186	.628	4.815	58
0010	E					RGR-SU-G1 1.00 SET UP A GAP GRINDER		1.05938		1.218	
0030	E					RLA-HP-C4 1.00 IRREG PART IN 4 JAW CHUCK		.22097		.254	
0040	E					RGR-GE-C2 98.00 GR CHROM OD (OCC FACT L X D) 7 X 14		.02189		2.467	
0050	E					RGR-GE-D3 7.00 DWELL (GAP GRINDER CHROM OD) 7 IN. O.D.		.02029		.163	
0060	E					RGR-WD-G2 2.00 WHEEL DRESS GAP GRINDER 2 PER OPERATION		.08334		.191	
70	E					KMG-GW-LK 2.00 LOCATE WHEEL TO POSITION 2 PER OPERATION		.06761		.155	
10	E					RGR-HM-T2 1.00 ADJUST TAPER - GAP GRINDER		.02632		.030	
0090	E					RGR-HM-C4 1.00 HANDLE & MEAS LENGTH 12 - 24		.10674		.122	
0100	E					RLG-RS-F4 42.00 FILE/GRIND & POL NICK/BURR CIRCUMFERENCE OF BOTH ENDS		.00415		.200	
0110	E					RJP-PW-R1 1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
9000			JA	01	15	.00	LABOR STANDARD HISTORY	.000	.000	.000	0
0010						26DEC85 RESTRUCTURED LABOR STD TO MATCH AFLC FORM					
0011						958/UPDATED OCCURRANCE FACTOR/WORK					
0012						PREVIOUSLY DONE ON OPER A0020 (OLD SRD).98					
0900						NED MONROE MANEAM 73357					

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-MH1-DY-M45 PAGE 0001

17575A CSA MLG 4611020-107A

RCC MNPRB

451-93-3

84013

CH S S W F PF A/R REV

STEP	DL	K	C	DC	ELEMENT	OCC FACT	DESCRIPTION STORED	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RB019	S	E	JA	EA	3	J	89006	.05 PERCENT ENGR 99.9	GRD TRUNNION PIN	10.23	.51	
0001			JA	01	00			PART NUMBER/NSN	.000	.000	.000	0
							4612400-101A	1620001162099				
0070			JA	01	15			1ST GRIND O.D.	3.058	.459	3.517	34
0010 E							RGR-SU-C2	1.00 SET UP SMALL MED CYL GRINDER	.29197		.335	
0020 E							RLA-HP-C3	1.00 CHUCK SYNET PART IN 4 JAW	.09095		.104	
0030 E							RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER	.02632		.030	
0040 E							KMG-DW-OD	1.00 DRESS EXTERNAL WHEEL	.02308		.026	
0050 E							KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION	.06761		.077	
0060 E							KMG-OD-PE	4.00 GRIND .010 7DIA X 3 LONG OCC FOR LENGTH	.59268		2.726	
0065 E							RGR-GE-D2	7.00 DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA	.01014		.081	
0070 E							RGR-HM-C4	1.00 HANDLE & MEAS LENGTH 12 - 24	.10674		.122	
0080 E							RJP-PW-R1	1.00 REM RPL PAPMARK SIGN OFF DOC	.01001		.011	
0080			JA	01	15			1ST GRIND I.D.	3.672	.028	.211	2
0010 E							RGR-SU-I1	1.00 S/U SMALL INTERNAL GRINDER	.49838		.573	
0020 E							RLA-HP-C3	1.00 CHUCK SYNET PART IN 4 JAW	.09095		.104	
0030 E							KMG-DW-ID	1.00 DRESS INTERNAL WHEEL	.02458		.028	
0040 E							KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION	.06761		.077	
0050 E							KMG-ID-NE	4.00 GRIND OUT .010 6.0 ID X 3.0 OCC FOR LENGTH	.71847		3.304	
0060 E							RGR-HM-C4	1.00 HANDLE & MEAS LENGTH 12 - 24	.10674		.122	
0070 E							RJP-PW-R1	1.00 REM RPL PAPMARK SIGN OFF DOC	.01001		.011	
			JA	01	15			POLISH LABOR	.372	.056	.428	4
010 E							RBW-SU-G1	.25 S/U FOR BENCH WORK GENERAL PRORATE OVER 4 PARTS	.27525		.079	
0020 E							RTL-SU-G1	1.00 SET UP A DIAL BORE GAGE	.08248		.094	
0030 E							RTL-MM-M1	1.00 MIKE ID OR 2 FLAT SURFACES	.00481		.005	
0040 E							ZPD-BP-C2	1.00 BUTTERFLY POLISH CYL I.D.	.15445		.177	
0050 E							ZIT-VI-B2	1.00 VISUAL INSP MEDIUM CYL I.D.	.05578		.064	
0060 E							RJP-PW-F1	1.00 SIGN OFF WORK CONTROL DOC	.00601		.006	
0132			JA	01	15			FINISH GRIND O.D.	4.596	.689	5.286	52
0010 E							RGR-SU-C2	1.00 SET UP SMALL MED CYL GRINDER	.29197		.335	
0020 E							RLA-HP-C3	1.00 CHUCK SYNET PART IN 4 JAW	.09095		.104	
0030 E							RGR-HM-T2	1.00 ADJUST TAPER - GAP GRINDER	.02632		.030	
0040 E							KMG-DW-OD	2.00 DRESS EXTERNAL WHEEL	.02308		.053	
0050 E							KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION	.06761		.077	
0060 E							KMG-OD-PK	4.00 GRIND .040 7DIA X 3 LONG OCC FOR LENGTH	.95369		4.386	
0065 E							RGR-GE-D3	7.00 DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA	.02029		.163	
0070 E							RGR-HM-C4	1.00 HANDLE & MEAS LENGTH 12 - 24	.10674		.122	
0080 E							RJP-PW-R1	1.00 REM RPL PAPMARK SIGN OFF DOC	.01001		.011	
0170			JA	01	15			FINISH GRIND I.D.	6.274	.047	.361	4
0010 E							RGR-SU-I1	1.00 S/U SMALL INTERNAL GRINDER	.49838		.573	
0020 E							RLA-HP-C3	1.00 CHUCK SYNET PART IN 4 JAW	.09095		.104	
0030 E							KMG-DW-ID	2.00 DRESS INTERNAL WHEEL	.02458		.056	
0040 E							KMG-GW-LK	1.00 LOCATE WHEEL TO POSITION	.06761		.077	
0050 E							KMG-ID-NK	4.00 GRIND OUT .040 6.0 ID X 3.0OCC FOR LENGTH	1.36294		6.269	
0060 E							RGR-HM-C4	1.00 HANDLE & MEAS LENGTH 12 - 24	.10674		.122	
0070 E							RJP-PW-R1	1.00 REM RPL PAPMARK SIGN OFF DOC	.01001		.011	
0170			JA	01	15			POLISH LABOR	.372	.056	.428	4
010 E							RBW-SU-G1	.25 S/U FOR BENCH WORK GENERAL PRORATE OVER 4 PARTS	.27525		.079	
020 E							RTL-SU-G1	1.00 SET UP A DIAL BORE GAGE	.08248		.094	
0030 E							RTL-MM-M1	1.00 MIKE ID OR 2 FLAT SURFACES	.00481		.005	
0040 E							ZPD-BP-C2	1.00 BUTTERFLY POLISH CYL I.D.	.15445		.177	
0050 E							ZIT-VI-B2	1.00 VISUAL INSP MEDIUM CYL I.D.	.05578		.064	
0060 E							RJP-PW-F1	1.00 SIGN OFF WORK CONTROL DOC	.00601		.006	
9000			JA	01	15			LABOR STANDARD HISTORY	.000	.000	.000	0



0011  
0012  
0900

958/UPDATED OCCURRENCE FACTOR/WORK  
PREVIOUSLY DONE ON OPER A0020 <OLD SRD>.98  
NED MONROE HAMEAN 73357

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA HLG 4611020-107A

RCC MNPRB

4S1-93-3

84013

CH S S		W F PF A/R REV		T K #R A FA SUPPORT		OCC <-----		DESCRIPTION ----->		BASE		PFD		STD		A	
STEP D L		K C DC ELEMENT		FACT		STORED		SUPPLEMENTAL		HOURS		TIME		HOURS		DLY PCT C	
RB020	S E	JA EA 3	J 88270	1.00	PERCENT ENGR 99.9			GRIND ANTI ROTATION BOLT		1.77				1.77			
0001		JA 01	00	1.00				PART NUMBER/NSM		.000		.000		.000			0
0010					4612433-101A			1620001177319									
0050		JA 01	15	1.00				1ST GRIND BOLT SHANK		.695		.104		.800			45
0010 E			RGR-SU-C2	1.00	SET UP SMALL MED CYL GRINDER,					.29197				.335			
0020 E			RLA-HP-C6	1.00	LOAD/UNLOAD SHL PART-CENTERS					.02466				.028			
0030 E			RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER ,					.02632				.030			
0040 E			KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL					.02308				.026			
0050 E			KMG-OD-DD	2.00	GRIND .010 1 1/2 OD X 2 1/2 OCCURANCE FOR LENGTH					.10917				.251			
0055 E			RGR-GE-D2	2.00	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA					.01014				.023			
0060 E			RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5 ,					.08102				.093			
0070 E			RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC					.01001				.011			
0120		JA 01	15	1.00				FINISH GRIND BOLT SHANK		.849		.127		.977			55
0010 E			RGR-SU-C2	1.00	SET UP SMALL MED CYL GRINDER,					.29197				.335			
0020 E			RLA-HP-C6	1.00	LOAD/UNLOAD SHL PART-CENTERS					.02466				.028			
0030 E			RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER ,					.02632				.030			
0040 E			KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL					.02308				.026			
0050 E			KMG-OD-DJ	2.00	GRIND .040 1 1/2 OD X 2 1/2 OCCURANCE FOR LENGTH					.17584				.404			
0055 E			RGR-GE-D3	2.00	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA					.02029				.046			
0060 E			RGR-HM-C2	1.00	HANDLE & MEAS LENGTH 1 TO 5 ,					.08102				.093			
0070 E			RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC					.01001				.011			
		JA 01	15	.00				LABOR STANDARD HISTORY		.000		.000		.000			0
010					24DEC85 RESTRUCTURED LABOR STD TO MATCH AFLC FORM												
0011					958/UPDATED OCC FACTORS/WORK PREVIOUSLY												
0012					DONE ON OPER A0220 <OLD STD> .41												
0900					NED MONROE NAMEAA 73357												

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4611020-107A

RCC NNPRB

451-93-3

84013

CH S S W F PF A/R REV

T K #R A FA SUPPORT

STEP	D L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY	PCT	A C
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RB024	S	E	JA	EA 3	J 88344	.50	PERCENT ENGR 99.9	GRIND TRUNNION C BOLT CSA M	3.36		1.68			
0001			JA	01	00	.00		PART NUMBER/NSN	.000	.000	.000		0	
							4613347-101A	5306004541547						
0060			JA	01	15	1.00		1ST GRIND SHANK	1.209	.181	1.391		41	
0010	E				RGR-SU-C2	.50	SET UP SMALL MED CYL GRINDER	PRORATE 2 PARTS	.29197		.167			
0020	E				RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028			
0030	E				RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030			
0040	E				KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026			
0050	E				KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077			
0060	E				KMG-OD-FE	3.70	GRIND .010 2 1/2 OD X 3	OCC FOR LENGTH	.21334		.907			
0065	E				RGR-GE-D2	2.50	DWELL (GAP GRINDER STEEL OD)	OCCURRANCED FOR DIA	.01014		.029			
0070	E				RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12.		.09717		.111			
0080	E				RJP-PW-R1	1.00	REN RPL PAPRMK SIGN OFF DOC		.01001		.011			
0130			JA	01	15	1.00		FINISH GRIND SHANK	1.715	.257	1.973		59	
0010	E				RGR-SU-C2	.50	SET UP SMALL MED CYL GRINDER	OCC FOR 2 PARTS	.29197		.167			
0020	E				RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028			
0030	E				RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030			
0040	E				KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026			
0050	E				KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077			
0060	E				KMG-OD-FK	3.70	GRIND .040 2 1/2 OD X 3	OCC FOR LENGTH	.34334		1.460			
0065	E				RGR-GE-D3	2.50	DWELL (GAP GRINDER CHROM OD)	OCCURRANCED FOR DIA	.02029		.058			
0070	E				RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12.		.09717		.111			
0080	E				RJP-PW-R1	1.00	REN RPL PAPRMK SIGN OFF DOC		.01001		.011			
0000			JA	01	15	.00		LABOR STANDARD HISTORY	.000	.000	.000		0	
0010							05NOV85	RESTRUCTURED LABOR STD TO MATCH AFLC FORM						
0011								958/UPDATED OCC FACTORS/WORK PREVIOUSLY						
0012								DONE ON OPER A0170 <OLD STD> .46						
0020								16JAN86 UPDATED OCC FACTORS <OLD STD> 1.36						
0900								NED MONROE MANEAM 73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NNPRB NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-WM1-BY-M45 PAGE 0001

17575A C5A MLG 4611020-107A

RCC MNPRB

4S1-93-3

84013

H S S W F PF A/R REV

STEP	D L	K C	DC	ELEMENT	OCC FACT	STOR	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	DLY PCT	A C
8025	S	E	JA	EA 3	J 89017	.29	PERCENT ENGR 99.9	GRIND S.B. APEX BOLT C-5A M	3.48		1.00		
0001			JA	01 00		.00		PART NUMBER/NSN	.000	.000	.000		0
				0010			4613537-101A	1620001164433					
0050			JA	01 15		1.00		1ST GRIND SHANK	1.247	.187	1.435		41
	0010	E			RGR-SU-C2	.50	SET UP SMALL MED CYL GRINDERPRORATE 2 PARTS		.29197		.167		
	0020	E			RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
	0030	E			RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
	0040	E			KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
	0050	E			KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
	0060	E			KMG-OD-GE	3.20	GRIND .010 3 OD X 3	OCC FOR LENGTH	.25700		.945		
	0065	E			RGR-GE-D2	3.00	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA		.01014		.034		
	0070	E			RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12.		.09717		.111		
	0080	E			RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
0120			JA	01 15		1.00		FINISH GRIND SHANK	1.779	.267	2.046		59
		0010	E		RGR-SU-C2	.50	SET UP SMALL MED CYL GRINDERPRORATE 2 PARTS		.29197		.167		
		0020	E		RLA-HP-C6	1.00	LOAD&UNLOAD SML PART-CENTERS		.02466		.028		
		0030	E		RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
		0040	E		KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
		0050	E		KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
		0060	E		KMG-OD-GK	3.20	GRIND .040 3 OD X 3	OCC FOR LENGTH	.41367		1.522		
		0065	E		RGR-GE-D3	3.00	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.070		
		0070	E		RGR-HM-C3	1.00	HANDLE & MEAS LENGTH 5 TO 12.		.09717		.111		
		0080	E		RJP-PW-R1	1.00	REN RPL PAPWRK SIGN OFF DOC		.01001		.011		
9000			JA	01 15		.01		LABOR STANDARD HISTORY	.000	.000	.000		0
		0010					05NOV85 RESTRUCTURED LABOR STD TO MATCH AFLC FORM						
		0011					958/UPDATED OCC FACTORS/WORK PREVIOUSLY						
		0012					DONE ON OPER A0040 <OLD STD> 1.09						
		0900					N. MONROE MANEAA 73357						

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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17575A CSA NLG 4611020-107A

RCC MNPB

TECH S S J F PF A/R REV

T K #R A FA SUPPORT

OCC

&lt;

DESCRIPTION

&gt;

BASE  
HOURSPFD  
TIMESTD  
HOURS

A

JSTEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

DLY PCT C

RB034	S	E	JA	EA	3	J	88174	.41	PERCENT ENGR 99.9	GRD ANLHOR SHAFT C-5A	2.80		1.14		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									4613366-101A	3040302284716LE					
0080			JA	01	15			.92		1ST GRIND O.D.	.584	.081	.619		22
0010 E							RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020 E							RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030 E							RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040 E							KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050 E							KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060 E							KMG-OD-EC	2.00	GRIND .010 2 OD X 2		.11834		.272		
0070 E							RGR-GE-D2	2.00	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA		.01014		.023		
0080 E							RTL-MM-M3	6.00	NIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00516		.042		
0090 E							RJP-PW-R1	1.00	REN RPL PAPMRK SIGN OFF DOC		.01001		.011		
0090			JA	01	15			.97		1ST GRIND O.D.	.455	.066	.508		18
0010 E							RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020 E							RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030 E							RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040 E							KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026		
0050 E							KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077		
0060 E							KMG-OD-CC	2.00	GRIND 010 1 OD X 2		.05867		.134		
0070 E							RGR-GE-D2	1.00	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA		.01014		.011		
0080 E							RTL-MM-M3	6.00	NIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090 E							RJP-PW-R1	1.00	REN RPL PAPMRK SIGN OFF DOC		.01001		.011		
			JA	01	15			.92		GRIND CHROME	.840	.116	.890		32
0010 E							RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020 E							RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030 E							RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040 E							KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050 E							KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION		.06761		.155		
0060 E							KMG-OD-EH	2.00	GRIND .040 2 OD X 2		.19084		.438		
0070 E							RGR-GE-D3	2.00	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.046		
0080 E							RTL-MM-M3	6.00	NIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090 E							RJP-PW-R1	1.00	REN RPL PAPMRK SIGN OFF DOC		.01001		.011		
0180			JA	01	15			.97		GRIND CHROME O. D.	.628	.091	.701		25
0010 E							RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083		
0020 E							RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104		
0030 E							RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030		
0040 E							KMG-DW-OD	2.00	DRESS EXTERNAL WHEEL		.02308		.053		
0050 E							KMG-GW-LK	2.00	LOCATE WHEEL TO POSITION		.06761		.155		
0060 E							KMG-OD-CH	2.00	GRIND .040 1 OD X 2		.09467		.217		
0070 E							RGR-GE-D3	1.00	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.023		
0080 E							RTL-MM-M3	6.00	NIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042		
0090 E							RJP-PW-R1	1.00	REN RPL PAPMRK SIGN OFF DOC		.01001		.011		
0185			JA	01	15			1.00		POLISH EDGES OF JOURNALS	.075	.011	.087		3
0010 E							ZPD-BP-C1	1.00		POLISH EDGES OF JOURNALS	.06549		.075		
0020 E							RJP-PW-R1	1.00	REN RPL PAPMRK SIGN OFF DOC		.01001		.011		
0000			JA	01	15			.01		LABOR STD HISTORY	.000	.000	.000		0
0010									01JUL83 OCC FACTOR CHG AVG 3 STUDIES						
020									PREVIOUS STD HRS 2.83						

STEP	D	L	K	C	DC	ELEMENT	FACT	STOR	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
0040	E	N	JA	EA	3	J 88334	1.00	PERCENT ENGR 42.3	CSA M. FLUID TRANS. HOUSING		.59		.59	
0001			JA	01	00		.00		PART NUMBER/NSN		.000	.000	.000	0
0010								4612583-103A	1620001157419					
0045			JA	01	15		1.00		HONE BUSHING/SUNNEN STROKER		.163	.025	.188	31
0010	E					ZHO-SU-S2	.25	SETUP SUNNEN HONE STROKER	PRORATE FOUR PARTS		.21517		.061	
0020	N						1.00		HONE BUSHING		.10000		.115	
0030	E					RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC			.01001		.011	
0050			JA	01	15		1.00		HONE BUSHING/SUNNEN STROKER		.163	.025	.188	31
0010	E					ZHO-SU-S2	.25	SETUP SUNNEN HONE STROKER	PRORATE FOUR PARTS		.21517		.061	
0020	N						1.00		HONE BUSHING		.10000		.115	
0030	E					RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC			.01001		.011	
0070							1.00		HONE BUSHING/SUNNEN STROKER		.163	.025	.188	31
0010	E					ZHO-SU-S2	.25	SETUP SUNNEN HONE STROKER	PRORATE FOUR PARTS		.21517		.061	
0020	N						1.00		HONE BUSHING		.10000		.115	
0030	E					RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC			.01001		.011	
0073			JA	01	15		1.00		POLISH I.D.		.029	.004	.034	6
0010	E					RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT			.01603		.018	
0020	E					RBW-BU-P1	1.00	BUTTERFLY POLISH BUSHING I D			.00333		.003	
0030	E					RJP-PW-R1	1.00	REM RPL PAPERWORK SIGN OFF DOC			.01001		.011	
9000			JA	01	00		.00		LABOR STANDARD HISTORY		.000	.000	.000	0
0010								9 JUNE 88 INITIAL INPUT MRPII						
0000								NED MONROE MANEL 73255 MR BIG						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD MROP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/16/89

A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC MMPRB

4S1-93-3

84013

H S S W F PF A/R REV

S	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PF	STD	A
STEP	D L	K C	DC	ELEMENT	FACT	STORED	HOURS	TIME	HOURS	DLY PCT C
0001	S E	JA	EA 3	J 89012	.79	PERCENT ENGR 99.9	1.75		1.38	
0001		JA	01	00	.00	GRIND REP BALLSCREW PIN CSAM	.000	.000	.000	0
0010						PART NUMBER/NSN				
0050		JA	01	15	1.00	4G13605-103A 5315001481779	.674	.101	.775	44
0010 E				RGR-SU-C2	.25	FIRST GRIND O.D.	.29197		.083	
0020 E				RLA-HP-C6	1.00	SET UP SMALL MED CYL GRINDER PRORATE 4 PARTS	.02466		.028	
0025 E				KMG-DW-OD	1.00	LOAD/UNLOAD SHL PART-CENTERS	.02308		.026	
0030 E				RGR-HM-T2	.25	DRESS EXTERNAL WHEEL	.02632		.007	
0040 E				RLG-EI-C8	1.00	ADJUST TAPER - GAP GRINDER PRORATE 4 PARTS	.00485		.005	
0050 E				KMG-DW-OD	1.00	MKE O/D WRE CHK BY MEASURING	.02308		.026	
0060 E				KMG-GW-LK	1.00	DRESS EXTERNAL WHEEL	.06761		.077	
0070 E				KMG-OD-EE	2.00	LOCATE WHEEL TO POSITION	.17200		.395	
0080 E				RGR-HM-C3	1.00	GRIND .010 2 OD X 3 OCC FOR LENGTH	.09717		.111	
0090 E				RJP-PW-R1	1.00	HANDLE & MEAS LENGTH 5 TO 12	.01001		.011	
0110		JA	01	15	1.00	REN RPL PAPWRK SIGN OFF DOC	.855	.128	.984	56
0010 E				RGR-SU-C2	.25	FINISH GRIND O.D.	.29197		.083	
0020 E				RLA-HP-C6	1.00	SET UP SMALL MED CYL GRINDER PRORATE 4 PARTS	.02466		.028	
0030 E				RGR-HM-T2	.25	LOAD/UNLOAD SHL PART-CENTERS	.02632		.007	
0040 E				KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL	.02308		.026	
0050 E				KMG-GW-LK	1.00	ADJUST TAPER - GAP GRINDER PRORATE 4 PARTS	.06761		.077	
0060 E				KMG-OD-EK	2.00	LOCATE WHEEL TO POSITION	.27684		.636	
0070 E				RGR-HM-C3	1.00	GRIND .040 2 OD X 3 OCC FOR LENGTH	.09717		.111	
0080 E				RJP-PW-R1	1.00	HANDLE & MEAS LENGTH 5 TO 12	.01001		.011	
9000		JA	01	15	.01	REN RPL PAPWRK SIGN OFF DOC	.000	.000	.000	0
0010						LABOR STANDARD HISTORY				
0020						28FEB85 INITIAL INPUT				
0900						26DEC85 UPDATED OCCURANCE FACTORS				
						N MONROE MANEAA 73357				

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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# LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

03/09/89

A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4611020-107A

RCC MNPRB

451-93-3

84013

CH S S W F PF A/R REV

T K #R A FA SUPPORT

OCC <-----

DESCRIPTION ----->

BASE

PFD

STD

A

STEP D L

K C DC ELEMENT

FACT

STORED

SUPPLEMENTAL

HOURS

TIME

HOURS

DLY PCT C

RB053	S	E	JA	EA	3	J	89068	.50	PERCENT ENGR 99.9	GRIND CSA METERING TUBE BASE	1.28		.64	
0001			JA	01	00			.00		PART NUMBER / NSN	.000	.000	.000	0
0010									4613519-101A	1620001233790				
0045			JA	01	15			1.00		IST GRIND O.D.	.497	.075	.572	45
0010 E							RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDER	PRORATE OVER 4 PARTS	.29197		.083	
0020 E							RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030 E							RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0040 E							KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026	
0050 E							KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0060 E							KMG-OD-JA	1.00	GRIND .010 4 OD X 1		.12900		.148	
0070 E							RGR-GE-D2	4.00	DWELL (GAP GRINDER STEEL OD)OCCURRANCED FOR DIA		.01014		.046	
0080 E							RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042	
0090 E							RJP-PW-R1	1.00	REM RFL PAPWRK SIGN OFF DOC		.01001		.011	
0087			JA	01	15			1.00		GRIND CHROME	.618	.093	.712	55
0010 E							RGR-SU-C2	.25	SET UP SMALL MED CYL GRINDERPRORATE OVER 4 PARTS		.29197		.083	
0020 E							RLA-HP-C3	1.00	CHUCK SYMET PART IN 4 JAW		.09095		.104	
0030 E							RGR-HM-T2	1.00	ADJUST TAPER - GAP GRINDER		.02632		.030	
0040 E							KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026	
0050 E							KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077	
0060 E							KMG-OD-JF	1.00	GRIND .040 4 OD X 1		.20967		.241	
0070 E							RGR-GE-D3	4.00	DWELL (GAP GRINDER CHROM OD)OCCURRANCED FOR DIA		.02029		.093	
0080 E							RTL-MM-M3	6.00	MIC O D FIRST MEASUREMENT 2 PLACES 3 CHECKS EACH		.00616		.042	
0090 E							RJP-PW-R1	1.00	REM RFL PAPWRK SIGN OFF DOC		.01001		.011	
0900			JA	01	00			1.00		LABOR STD HISTORY	.000	.000	.000	0
									LLOYD A. HARGIS MANEL-1	73357				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NROP NR

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## WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040

PAGE 2 OF 2 PAGES

1. ORDER NO.	2. QUANTITY	3. PRODUCTION SEC/RCC	4. DATE SCHED.	5. DATE COMPLETED
6. PART NUMBER		7. TECH DATA		8. ITEM SERIAL NO.

9. MODEL-DESIGN-SERIES	10. STOCK NUMBER	11. OPTIONAL
12. SERIAL NUMBER	13. NOUN	

14. DISPATCH STATION	15. PERP RCC/OP NO.	16. WORK TO BE ACCOMPLISHED	17. MECHANIC	18. "P"	19. "Q"
		COLUMN 16 IS EQUIVALENT TO OLD TA STAMP.			
	001	B 15576-2R			
		DISASSEMBLE	NO/P MOVE	001 MNPGR	
	MRE00*			002 01	
				003 1000	
		WREN CLEAN	NO/P MOVE	001 MNPGR	
	MRE00*			002 02	
				003 1001	
		WREN CLEAN	NO/P MOVE	001 MNPGR	
	MRE00*			002 02	
				003 1001	
		SAVE 4 HRS AT 250-4000		001 MNPGR	
	MRE00*	DATE IN _____ TIME IN _____		002 03	
				003 1000	
		WREN CLEAN	NO/P MOVE		
		WREN CLEAN	NO/P MOVE	001 MNPGR	
	MRE00*			002 03	
				003 1000	
		E & I NOT VISUAL INSPECT FOR FITTING		001 MNPGR	
	MRE00*	GOING, CORROSION, REMOVE MINOR		002 04	
		FLICKS	NO/P MOVE	003 EI01	
20	001	WREN LUBREASE	NO/P MOVE	001 MNPGR	
				002 03	
				003 DG01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21066N
		B	D	

## 21066N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN BALLNUT						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26	028	STRIP CAD *C/P MOVE					001 001 001	002 02 003 0501	
26	030	STRIP RUST *C/P MOVE					001 001 001	002 02 003 0502	
26	035	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED *C/P MOVE					001 001 001	002 01 003 0502	
26	040	CAD PLATE O.D. *C/P MOVE					001 001 001	002 05 003 0501	
26	050	EMUL 250-400P FOR 12 HRS X 12 HRS 3 HRS OF PLATE 12 HRS IN 12 HRS 12					001 001 001	002 01 003 0501	
		DATE CUT TIME OUT *C/P MOVE							
		***** IF LAST NO OPERATION ALL OF STOCK PIRE, TAKE PRODUCTION COUNT *****							
26	061	100 PLATE (INITIATED BY PLATING) *C/P MOVE							
26	052	ALDINE 100 PLATED AREAS (INITIATED BY PLATING) *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21066N			
		B		D					

368

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN BALLAST						
18. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26	063	VAPOR DEGREASE *C/P MOVE					001 MPRC 002 03 003 PG01		
25	067	PRIOR TO PHOSPHATE, GRIT BLAST ALL AREAS TO BE PHOSPHATE COATED *C/P MOVE					001 MPRC 002 01 003 BL02		
25	070	PHOSPHATE COAT BALL TRACK TYPE M CLASS II *C/P MOVE					001 MPRC 002 03 003 PH01		
26B	000	MAKE MIN OF 8 HRS AT 210-225F DATE IN TIME IN					001 MPRC 002 02 003 8803		
		DATE OUT TIME OUT *C/P MOVE							
5	025	IRIDITE *C/P MOVE					001 MPRC 002 02 003 1103		
	040	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETE LAYDOWN & ACCEPTANCE OF ALL PRECEDING OPERATIONS. THIS IS A *REQU*					001 MPRC 002 01 003 1103		
	100	FINAL PROJECT VISUAL ACCEPTANCE *C/P MOVE *REQU*					001 MPRC 002 01 003 1103		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21066N			
		B		D					

## 21067N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 1 OF 1 PAGES

2. JOB ORDER NO. 74652A		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER B15576-13R				8. TECH DATA 16G3-2-80-3/4S-1-182 AND SUPPLEMENTS				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES CSA MAIN		11. STOCK NUMBER 1620010064608				12. OPTIONAL			
13. SERIAL NUMBER		14. NOUN DOG STOP							
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "G"	
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 BAKE IAW 4S-1-182 MADT 74-12							
		IVD PLATE IAW MIL-C-83488A CAD PLATE IAW MIL-STD-870 TP II CL II FMPI IAW MIL-STD-1949							
		ALODINE IAW MIL-C-5541 P/O N01561 BLAST IAW MIL-STD-1504 MAT'L: STEEL (204,000 KSI) COST: \$296.37							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				21067N			
		B							
		C							
		D							

370

## 21067N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN DOG STOP						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
	001	B15576-13R							
34C5	005	DISASSEMBLE *C/P MOVE					001 MNP GP		
	*REQD*						002 01		
							003 SL03		
34C	007	CHEM CLEAN *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 SL01		
34B	009	BLAST CLEAN *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 BL07		
34B	011	BAKE 4HR AT 350-400F					001 MNP GW		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
		DATE OUT _____ TIME OUT _____					003 BK03		
		*C/P MOVE							
34M	013	FMPI / *C/P MOVE				M	001 MNP NA		
	*REQD*						002 05		
							003 MS03		
34E	030	E & I VISUAL INSPECT /REMOVE MINOR NICKS					001 MNP GW		
	*REQD*	*C/P MOVE					002 04		
							003 E101		
26	032	VAPOR DEGREASE *C/P MOVE					001 MNPRC		
							002 03		
							003 DG01		
26	034	STRIP CAD *C/P MOVE					001 MNPRC		
							002 03		
							003 CS01		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21067N
		B	D	

371

## 21067N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN DOG STOP						
18. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26	036	STRIP RUST *C/P MOVE					001 MNPRC 002 02 003 C502		
26	038	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE					001 MNPRC 002 01 003 BL04		
26	040	CAD PLATE TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CA01		
26B	050	BAKE 23HR AT 350-400F WITHIN 4 HRS OF CAD PLATE. DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	060	IRIDITE *C/P MOVE					001 MNPRC 002 02 003 IR01		
8A	065	FNPI *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****				M	001 MNPNA 002 04 003 ML04		
26	066	IVD PLATE (INITIATED BY PLATING) *C/P MOVE					001 MNPRC 002 03 003 IV01		
26	067	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE					001 MNPRC 002 03 003 TA01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21067N			
		B		D					

PAGE 4 OF 4 PAGES

873



## 21068N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 1 OF 1 PAGES

2. JOB ORDER NO. 74652A		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER B15576-10			8. TECH DATA 16G3-2-80-3/4S-1-182 AND SUPPLEMENTS				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES C-5A M.L.G.		11. STOCK NUMBER 5310010060370			12. OPTIONAL				
13. SERIAL NUMBER		14. NOUN HEX NUT							
18. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALODINE IAW MIL-C-5541 IWD PLATE IAW MIL-C-83488A BLAST IAW MIL-STD-1504 BAKE IAW 4S-1-182 MAOI 74-12 EMPI IAW MIL-STD-1949 P/O N01561 CAD PLATE IAW MIL-STD 870 TP II CL II **COST: \$54.34** **MAT'L STEEL 196,000 KSI** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. *****"W A R N I N G"***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES *REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21068N			
		B		D					

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN HEX NUT						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
	001	B15576-10							
34C5	005 *REQD*	DISASSEMBLE *C/P MOVE					001 MNP GP 002 01 003 SI03		
34C	007 *REQD*	CHEM CLEAN *C/P MOVE					001 MNP GW 002 03 003 SL01		
34B	009 *REQD*	BLAST CLEAN *C/P MOVE					001 MNP GW 002 03 003 BL07		
34B	011 *REQD*	BAKE 4 HRS AT 350-400F DATE IN _____ TIME IN _____					001 MNP GW 002 03 003 BK03		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
34M	013 *REQD*	FMPI *C/P MOVE				M	001 MNP NA 002 05 003 MS03		
34E	030 *REQD*	E & I - VISUAL INSPECT/ REMOVE MINOR DEFECTS *C/P MOVE					001 MNP GW 002 04 003 EI01		
26	032	VAPOR DEGREASE *C/P MOVE					001 MNP RC 002 03 003 DG01		
26	034	STRIP CAD *C/P MOVE					001 MNP RC 002 03 003 CS01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21068N			
		B		D					

## 21068N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN HEX NUT						
18. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				19. MECHANIC	18. "P"	20. "Q"	
26	036	STRIP RUST *C/P MOVE					001 MNPRC 002 02 003 CS02		
26	038	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE					001 MNPRC 002 01 003 BL02		
26	040	CAD PLATE DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 03 003 CA01		
26B	050	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD PLATE DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	060	IRIDITE *C/P MOVE					001 MNPRC 002 02 003 IR01		
BA	070	F.M.P.I. ] *C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****				M	001 MNPNA 002 06 003 ML04		
26	072	IVD PLATE (INITIATED BY PLATING) *C/P MOVE					001 MNPRC 002 03 003 IV01		
26	074	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE					001 MNPRC 002 03 003 TA01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21068N			
		B		D					

## 21068N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 4 OF 4 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN HEX NUT						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
34C5	080 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNP GP 002 01 003 ML 06		
34C5	090 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNP GP 002 01 003 ML 06		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21068N			
		B		D					

## 21088N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES C-5A MLG		11. STOCK NUMBER		12. OPTIONAL AF DWG 7926445 4S1-93-3 4S1-182					
13. SERIAL NUMBER		14. NOUN PISTON SUB-ASSY				17687A			
19. DISPATCH STATION	18. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				16. MECHANIC	15. 17575A		
P/N 7926445		NSN C/N 1620010805925 17687A 17525A 17576A 17577A 17578A					4		
							7		
		GOVERNING DIRECTIVES: AFLOR 66-51 MANO1 66-3					8		
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT							
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.							
		SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		*****"W A R N I N G"*****							
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS							
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP							
	001	7926445							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21088N			
		B		D					

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN PISTON SUB-ASSY						
18. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				19. MECHANIC	19. "P"	20. "Q"	
	010	* *MATCH - UP* *					001 MNR GP		
		NEW/SERVICEABLE REWORKED NO REWORK INNER CYL					002 01		
		21002N FLOATING PISTON					003 MU06		
		21047N PISTON CARRIER							
		21052N PISTON STOP TUBE							
		21043N METERING TUBE BASE							
		21053N GAUGE							
		21059N							
34C5	015	PREASSEMBLY CLEANING; INSPECT ALL CAVITIES AND PASSAGES FOR *REQD* CLEANLINESS AND SCRATCHES OK TO ASSEMBLE/OR CLOSE					001 MNR GP		
							002 01		
							003 PA07		
34C5	020	ASSEMBLE TOGETHER ALL PARTS REQUIRED TO BUILD THE HIGH PRESSURE PISTON *REQD* ASSY AND INSTALL INTO INNER CYL					001 MNR GP		
							002 01		
							003 PA07		
34C5	025	POUR APPROX 1 PT LIGHT OIL INTO LOWER CHAMBER. PLACE SUBASSY INTO *REQD* TEST FIXTURE AN SECURE.					001 MNR GP		
							002 01		
							003 PA07		
							004 PA0001		
34C5	030	CHARGE PISTON SUBASSY WITH 2500 PSI AND TEST IAW 4S1-93-3 PARA 6-6 PAGE *REQD* 6-10					001 MNR GP		
							002 01		
							003 PA07		
							004 PA0001		
34C5	035	RECORD LEAKAGE; 1ST HOUR _____ 2ND HOUR _____ *REQD* 3RD HOUR _____ 4TH HOUR _____					001 MNR GP		
							002 01		
							003 PA07		
							004 PA0001		
34C5	040	UPON COMPLETION OF TEST, DRAIN OFF NITROGEN AND SAFETY WIRE AS REQUIRED *REQD* *C/P MOVE					001 MNR GP		
							002 01		
							003 PA07		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21088N			
		B		D					



## 21089N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA 451-93-3 451-182				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C-5A			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN MLG STRUT DISASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
P/N		NSN C/N							
4611020-107A		1620010054191 17575A							
4611020-105A		1620010054192 17576A							
4611020-101A		1620010054193 17577A							
4611020-103A		1620010054194 17578A							
		GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT							
		HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.							
		SUPPLEMENTS REFERENCED. THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		*****"W A R N I N G"***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS							
		WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP							
		YOKE SERIAL NUMBER. _____							
		OUTER SERIAL NUMBER. _____ (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						21089N			
						381			



## 21089N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN MLG STRUT DISASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		INNER CYL SERIAL NUMBER _____							
		SPLINED TUBE SERIAL NO. _____							
		ROLL PIN SERIAL NUMBER _____							
	001	4G11020-107A 4G11020-105A 4G11020-101A 4G11020-103A							
34C5	*REQD*	OPEN SHIPPING CRATE AND REMOVE TIE DOWN STRAPS FROM CRADDES. REMOVE APEX PIN, SIDE BRACE ARMS AND ATTACHING HARDWARE FROM STRUT.					001 MNP GP 002 01 003 CC22		
		ATTACH WORK CONTROL DOCUMENT AND ROUTE.							
34C5	*REQD*	WITH A STRAP HOLD THE INNER CYL IN COLLAPSED POSITION. ATTACH LIFTING SLING THROUGH THE ROLL PIN AND LIFT STRUT TO THE VERTICLE POSITION UP SIDE DOWN.					001 MNP GP 002 01 003 CC22		
34C5	*REQD*	REMOVE "Y" BLOCK AND DRAIN HYDRAULIC FLUID FROM UPPER CHAMBER INTO A WASTE OIL DRUM. REMOVE TRUNNION PIN AND RETRACT ARM ASSY. DISASSEMBLE RETRACT ARM. ATTACH WCD AND ROUTE					001 MNP GP 002 01 003 CC22		
34C5	*REQD*	ROLL STRUT INTO UPRIGHT POSITION AND MOVE INTO DISASSEMBLY STAND. BE SURE LOWER CHAMBER HAS NO AIR IN (CONTINUED)					001 MNP GP 002 01 003 SD03 004 PM5573		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21089N			
		B		D					

## 21089N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN MLG STRUT DISASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		IT. (REMOVE ROLL POSITIONERS, CLEAN AND TAG COND "F".							
34C5	023 *REQD*	REMOVE ROLL PIN AND ATTACHING PARTS. REMOVE FLUID TRANSFER HOUSING. ATTACH WCD'S AND ROUTE. REMOVE STAND PIPE, FLEX HOSE, AND JUNCTION BOX.					001 MNP GP 002 01 003 SD03 004 PM5573		
34C5	020 *REQD*	REMOVE ALL HYD LINES AND TUBING FROM THE KNEELING SYSTEM. REMOVE THE HYD MOTOR, HYD BRAKE AND GEAR BOX. DRAIN HYD FLUID CLEAN AND CAP. TAG COND "F".					001 MNP GP 002 01 003 SD03 004 PM5573		
34C5	021 *REQD*	REMOVE CHAIN COVER, KNEELING CHAINS, GEAR DRIVE HOUSING. DISASSEMBLE THE GEAR DRIVE HOUSING. ATTACH WCD'S AND ROUTE.					001 MNP GP 002 01 003 SD03 004 PM5573		
34C5	022 *REQD*	REMOVE NORM & ENG ROTATION CYLS. DRAIN, CAP AND CLEAN. TAG COND "F". REMOVE ALL HYD TUBING AND FLEX HOSES TO CROSS WIND CYLS. CLEAN TUBING AND HOSES AND STORE FOR REUSE.					001 MNP GP 002 01 003 SD03 004 PM5573		
		***** NOTE ***** ON COMPONENTS BEING STORED FOR REUSE VISUALLY INSPECT FOR CLEANLINESS AND SERVICEABILITY BEFORE STORING							
34C5	045 *REQD*	DISCONNECT ELECT WIRES AT ELECT JUNCTION BOX. REMOVE LINEAR SHUTOFF VALVES FROM BRACKETS. DRAIN, CAP, (CONTINUED)					001 MNP GP 002 01 003 SD03 004 PM5573		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21089N			
		B		D					

382

7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL	
13. SERIAL NUMBER		14. NOUN MLG STRUT DISASSY			
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED		18. MECHANIC	19. "P"
		CLEAN AND TAG ---COND---"F". REMOVE LINEAR TRANSDUCERS CLEAN AND STORE			
		***** NOTE ***** USE CARE IN REMOVING ELECT. WIRING HARNESS TO AVOID DAMAGE. ELECT WIRING HARNESS SHOULD BE REUSED.			
		*****			
34C5	050 *REQD*	REMOVE AND CLEAN ID'S OF CROSS WIND APEX BOLT AND ANTI ROTATION BOLTS. ATTACH WCD'S AND ROUTE. REMOVE AND DRAIN. CAP AND CLEAN CROSS WIND CYLS, NORM & EMG LOCK CYLS TAG F CONDITION.			001 MNP GP 002 01 003 SD03 004 PM5573
34C5	055 *REQD*	REMOVE ALL HYD TUBING AND FLEX LINES IN SEQUENCE, ALL HYD FITTINGS AND VALVES. CLEAN AND STORE FOR REUSE. REMOVE ELECT. WIRING HARNESS, SYNCHRO TRANS. ATTACH WCD'S & -ROUTE			001 MNP GP 002 01 003 SD03 004 PM5573
34C5	060 *REQD*	REMOVE ROTATION SHAFTS, BRACKETS AND COVERS, BALLSCREW CROSS PINS. REMOVE ELECT. INSERT, CROSS WIND AND ROTATION MANIFOLDS. DRAIN. CAP AND CLEAN. TAG COND "F".			001 MNP GP 002 01 003 SD03 004 PM5573
34C5	068 *REQD*	REMOVE STOP PLATE, ROTATION COLLAR, AND INSERTS. REMOVE AND DISASSEMBLE THE LOCK RING ASSY. LOCK ACT COLLAR (CONTINUED)			001 MNP GP 002 01 003 SD03 004 PM5573
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	21089N	
		B	C		

## 21089N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 5 OF 5 PAGES

1. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN MLG STRUT DISASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		AND POSITIONING COLLAR. ATTACH WORK CONTROL DOCUMENTS AND-ROUTE.							
34C5	678 *REQD*	UNSCREW PACKING NUT FROM OUTER CYL DROP THE SPLINED TUBE INTO THE INNER CYL I.D. PLACE INNER CYL IN HOLDING CART AND SEPARATE THE INNER CYL FROM THE OUTER CYL. MOVE FROM UNDER STAND					001 MNP GP 002 01 003 SD03 004 PM5573		
34C5	678 *REQD*	REMOVE OUTER CYL FROM YOKE, AND PLACE IN A "V" CART. REMOVE ALL BUSHINGS. REMOVE BALLSCREWS FROM YOKE AND DISASSEMBLE. ATTACH WCD'S AND-ROUTE					001 MNP GP 002 01 003 SD03 004 PM5573		
34C5	680 *REQD*	REMOVE AND DISASSEMBLE SPLINED TUBE. DISASSEMBLE HIGH PRESSURE PISTON ASSEMBLY FROM INNER CYL. REMOVE YOKE ASSY. FROM STAND, CLEAN EXCESS GREASE FROM TRUNNIONS. ATTACH WCD'S AND-ROUTE.					001 MNP GP 002 01 003 SD03 004 PM5573		
34C5	685 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY ALL PRECEDING OPERATIONS THIS 958.					001 MNP GP 002 01 003 SD03		
34C5	690 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNP GP 002 01 003 SD03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21089N			
		B		D					



## 21091N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

PAGE 2 OF 2 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	

15 DISPATCH STATION	16 PERFORM RCC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		Block 16 serves the same purpose as Delta Stamp			
	001	ADDISONITE			
	005	REPAIR		001 MRPGW	
				002 01	
				003 E101	
				001 MRPGW	
				002 01	
				003 E101	
				001 MRPGW	
				002 01	
				003 E101	
				001 MRPGW	
				002 04	
				003 E101	
69	04Q	END HOLE OVERSIZE REPAIR. OVERSIZE TO CLEAN UP NOT TO EXCEED I.D. 0.937		001 MRPGW	
				002 02	
				002 LE02	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21091N
		B	D	

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
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13 SERIAL NUMBER	14 NOUN
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15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
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		IF THREADED END IS DAMAGED OR NOTICED CRACKED THERE IS A REPAIR TO CUT OFF AND MAKE A REPLACEMENT ORDER			
--	--	---	--	--	--

69	045	THREADED END REPAIR. IF DAMAGED, REPAIR OR ORDER CUT OFF AND REORDER			
----	-----	--	--	--	--

69	050	DRILL ALL HOLES IN FITTING AS PER 451-93-3 PAGE 5-10 CUT PART 2			
----	-----	---	--	--	--

		REMOVE ALL REMAINING HOLES			
--	--	----------------------------	--	--	--

69	060	LOCALLY MFG A STOP (INSERT) AS SHOWN IN FIG 5-21 OF 451-93-3 USING 4130			
----	-----	---	--	--	--

		REPAIR IF NEEDED			
--	--	------------------	--	--	--

		REMOVE ALL REMAINING HOLES			
--	--	----------------------------	--	--	--

26	070	REMOVE ALL REMAINING HOLES			
----	-----	----------------------------	--	--	--

26	077	IRIDITE			
----	-----	---------	--	--	--

26	080	IVS PLATE (INITIATED BY PLATING)			
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21091N
		B	D	

## 21091N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

PAGE 4 OF 4 PAGES

2 JOB ORDER NO.		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN SPECIAL - G (CUTL. MED)						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69	082	ALIGNING IVS PLATED AREAS INITIATED BY PLATING *O/P MOVE					001 MARR 002 03 003 TAG1		
69	085	MACHINE END HOLE BUSHINGS R/M 44-104010 *O/P MOVE					001 MARR 002 02 003 1202		
69	090	INSTALL END HOLE BUSHINGS DIAMETER I.D. 0.7505/0.7515 *O/P MOVE					001 MARR 002 02 003 2001		
69	095	INSTALL INSERT IN FITTING WITH LOCTITE MIL-S-22473 *O/P MOVE					001 MARR 002 02 003 2001		
69	100	IF INSERT HAS BEEN HEAT TREATED CHASE THREADED END AFTER HEAT TREAT *O/P MOVE					001 MARR 002 02 003 2001		
	105	RE-ALIGN AND MEAS. FRAME FOR R/R IAX 45-1-102 *O/P MOVE					001 MARR 002 02 003 2001		
	110	FINAL ALIGNMENT OF WORK IN ALL DOCUMENT FOR COMPLETION OF *O/P MOVE					001 MARR 002 02 003 2001		
	115	FINAL ALIGNMENT VERTICAL *O/P MOVE *REDO*					001 MARR 002 02 003 2006		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21091N	
		B	D		



## 11 DATE

PAGE\_\_OF\_\_PAGES

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
1107481			09/04/5	1

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	17575

17575A

[illegible]

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	210240 390

**PAGE \_\_\_ OF \_\_\_ PAGES**

21094N

591

2. JOB ORDER NO. <b>14652A</b>		3. QUANTITY		4. PRODUCTION SEC/RCC <b>MNPGP</b>		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER <b>4G94034-101A</b>				8. TECH DATA <b>16G3-2-80-3 4S1-182</b>				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES <b>C5A MLG</b>			11. STOCK NUMBER <b>1620001486466</b>			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN <b>BALLSCREW DISASSY</b>						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		*****W A R N I N G***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP							
	001	4G94034-101A							
34C5	<b>*REQD*</b>	CUT SAFETY WIRE AND REMOVE HEX NUT AND DOG STOP FROM END OF BALLSCREW					001 MNPGP 002 01 003 SD03		
34C5	<b>*REQD*</b>	ROTATE BALLNUT OFF THE END OF THE BALLSCREW AND REMOVE ALL THE BALL BEARING FROM I.D. OF BALLNUT					001 MNPGP 002 01 003 SD03		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21098N			
		B		D					

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN BALLSCREW DISASSY						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
34C5	*REQD*	REMOVE GREASE FROM BALL BEARINGS AND RECORD THE SIZE OF THE BALLS FOR REFERENCE UPON REASSEMBLY OF BALL-SCREW.					001 MNP GP	002 01	003 SD03
34C5	*REQD*	CLEAN SEALANT FROM RETURN TUBES AND TUBE STRAP, CUT SAFETY WIRE AND REMOVE HEX NUT HOLDING DEFLECTOR YOKES. REMOVE SCRAPERS AND DRIVE PINS AND RETURN-TUBES.					001 MNP GP	002 01	003 SD03
34C5	*REQD*	SCRAPE SEALANT FROM BALLNUT TO REMOVE AS MUCH AS POSSIBLE. REMOVE ZERK-FITTING AND REMOVE "D" RING AND DISCARD.					001 MNP GP	002 01	003 SD03
34C5	*REQD*	REMOVE EXCESS GREASE FROM BALLNUT AND ATTACH WORK CONTROL DOCUMENTS & ROUTE.					001 MNP GP	002 01	003 SD03
34C5	*REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNP GP	002 01	003 SD03
34C5	*REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNP GP	002 01	003 SD03
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21098N			
		B		D					

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNP6P	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 451-182 451-90-00 600 100 IMPLEMENTS	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES C-5A HLG	11. STOCK NUMBER	12. OPTIONAL <b>17575A</b>
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13. SERIAL NUMBER	14. NOUN SWITCH PTD 1111
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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P/N 4612586-101A		1520001157397 17575A <b>17576A</b> 17577A 17578A			
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		FOLLOWING DIRECTIVES: AFM 1-100 MAND 1-100 BLAST CAN MIL-STD-1504 FBI CAN MIL-STD-1504			
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		ALUMINE 1AN MIL-C-5541 EYE PLATE 12W MIL-C-80710-4 OAB PLATE 1AN MIL-C-80710-4 TO 11-11-11			
--	--	---	--	--	--

		ALL PERSONNEL INVOLVED IN THE WORK INVOLVEDS SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT THEORY			
--	--	---	--	--	--

		PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED, THE ABOVE LISTED T.O. AND SUPPLEMENTS WILL			
--	--	--	--	--	--

		ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. ACCORDINGS WILL BE FOLLOWED CLEARLY AND PROSECUTED BY THE			
--	--	---	--	--	--

		MOVES BETWEEN OPERATIONS/REPAIR STATIONS *****M A R N I N *****			
--	--	--	--	--	--

		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND			
--	--	--	--	--	--

		PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN (CONTINUED)			
--	--	--	--	--	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	21093N	
		B	D		

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN SWING, FID (114)						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		BLOCK 15 SERVES THE SAME PURPOSE AS DELTA STAMP							
	001	4612555-101A							
	005	DISASSEMBLE *C/P MOVE*					001 MNH SW		
	*REDD*						002 01		
							003 5003		
		CHEN CLEAN *C/P MOVE*					001 MNH SW		
	*REDD*						002 03		
							003 6001		
		BLAST CLEAN ONLY *C/P MOVE*					001 MNH SW		
	*REDD*						002 03		
							003 6107		
		*C/P MOVE*				M	001 MNH SW		
	*REDD*						002 05		
							003 2105		
		B & I INSPECTION FITTING SHANK (LARGE) 0.5. 0.749/0.750 BEAR 0.747					001 MNH SW		
	*REDD*	SAL HOLE INSIDE 1.1. 0.7505/0.7515					002 04		
		WEAR 0.7505 0.7515 END HOLE 1.00E 0.7515					003 2107		
		I.D. 0.939 *C/P MOVE*							
		REMOVE BUSHINGS *C/P MOVE*					001 MNH SW		
							002 04		
							003 E101		
69	040	END HOLE OVERSIZE REPAIR OVERSIZE TO CLEANUP NOT TO EXCEED 0.009 IF THREADED END IS DAMAGED OR (CONTINUED)					001 MNH SW		
							002 02		
							003 LE02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				21093N			
		B							
		C							
		D							

2. JOB ORDER NO. 173-76A		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C5A MLC		11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER		14. NOUN SM (VEL. FITG (INT)							
18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		NOTE: CRACKED. THERE IS A REPAIR TO CUT OFF AND MAKE A REPLACEMENT INSERT *C/P MOVE							
69	045	THREADED END REPAIR IF DAMAGED. CRACKED OR BROKE. CUT OFF THREADED END AND FACE OFF AND USE FITTING *C/P MOVE					001 MNRCA 002 02 003 02		
69	050	DRILL ALL HOLES IN FITTING AS PER 491-93-3 PARA 5-10 SUB PARA 1 *C/P MOVE					001 MNRCA 002 02 003 02		
69	055	REMOVE ALL REMARKED AREAS *C/P MOVE					001 MNRCA 002 02 003 02		
69	060	LOCALLY MFG A STUD (INSERT) AS SHOWN IN FIG 5-21 OF 491-93-3 USING A16 HEAT TREATED STEEL OR EQUIVALENT *C/P MOVE					001 MNRCA 002 02 003 02		
		[REDACTED] INSERT TO 40-130 *C/P MOVE					001 MNRCA 002 02 003 02		
69	070	PREPARE INSERT FOR CAD PLATING PLATE. DRILL BLANK *C/P MOVE					001 MNRCA 002 02 003 02		
69	075	CADMIUM PLATE IMBLANK *C/P MOVE					001 MNRCA 002 02 003 02		
69	077	IRIDITE *C/P MOVE					001 MNRCA 002 02 003 02		
69	080	IVD PLATE (INITIATED BY PLATING) *C/P MOVE					001 MNRCA 002 02 003 02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21093N			
		B		D					

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN SWIVEL PDS (INT)						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
68	062	ALLODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE					001 MM RL 002 03 003 TA01		
69	085	MACHINE END HOLE BUSHINGS E/N M521211-2A010					001 MM RA 002 02 003 LB02		
69	090	INSTALL END HOLE BUSHINGS DIAMETER I.D. 0.7505/0.7515					001 MM RA 002 02 003 BE01		
69	095	INSTALL INSERT IN FITTING WITH LOCTITE NTL-S-22479					001 MM RA 002 02 003 LB01		
69	100	IF INSERT HAS BEEN HEAT TREATED CHASE THREADED END AFTER HEAT TREAT					001 MM RA 002 02 003 BE01		
	102	DEGLAZE AND MASK, PRIME AND PAINT TAW 451-152 *C/P MOVE					001 MM RA 002 09 003 LB02		
	10	FINAL ALL-CHANGE IF WORK CONTROL DOCUMENT FOR COMPLETION OF ALL PRECEDING WORK					001 MM RA 002 02 003 LB02		
	115	FINAL PRODUCT MATERIAL *C/P MOVE					001 MM RA 002 02 003 LB02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21093N			
		B		D					



21092N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

1  
PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MARP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 481-182 481-93-B AND SUPPLEMENTS	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES C-5A MLG	11. STOCK NUMBER	12. OPTIONAL <b>17575A</b>
13. SERIAL NUMBER	14. NOUN BULVED 100 AL WIDE	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/N 4612554-101A		NSN 162000-157396	C/N 17575A 17576A 17577A 17578A		
		GOVERNMENT DIRECTIVES: AFM 48-01 MANC 48-0 BLAST 14M MIL-STD-15-4 EDT 14M MIL-STD-15-4			
		ALDINE 14M MIL-STD-15-4 CAB PLATE 14M MIL-STD-15-4 TP 11 01 11 IUD 14M MIL-STD-15-4			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND SUPPLEMENT. REFERENCED, THE FOLLOWING IS A SUMMARY OF THE SAFETY PRECAUTIONS TO BE OBSERVED:			
		BEFORE WORKING ON ANY OF THE EQUIPMENT, THE PERSONNEL MUST BE THOROUGHLY TRAINED AND FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND SUPPLEMENT.			
		MOVES PERSONNEL TO THE WORK STATIONS, AND WHEN WORKING ON ANY OF THE EQUIPMENT, PERSONNEL MUST BE THOROUGHLY TRAINED AND FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND SUPPLEMENT.			
		PROCEDURES REQUIRING THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD (MANDATORY REQUIREMENT) IN (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21092N
		B	D	

1

21092N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89045

2 PAGE OF PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO.
---------------	-------------	-------------------

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN SWIVEL P/B (L-RHS)	

15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 "P"	20 "Q"
		BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	13125-4-1014			
34B	001	DISASSEMBLE		001 MRKKA 002 01 003 0101	
34C	001	SWIVEL CLEAN		001 MRKKA 002 02 003 0101	
34D	001	SWIVEL CLEAN ONLY		001 MRKKA 002 01 003 0101	
34Z	015	FPI		001 MRKKA 002 01 003 0101	
34E	001	L & L INSULATION CARTRIDGE WITH 1/2" DIA. O.D. 0.749/0.750 SEAL 3.241 EX. HOLE BUSHING I.D. 0.750/0.751 O.D. 0.7505 MAX END HOLE 0.751/0.752 O.D. 0.751		001 MRKKA 002 01 003 0101	
34E	005	REMOVE BUSHINGS	*C/P MOVE*	001 MRKKA 002 04 003 0101	
369	040	END HOLE OVERSIZE REPAIR OVERSIZE TO CLEAN UP NOT TO EXCEED I.D. 0.929	*C/P MOVE*	001 MRKKA 002 02 003 LE02	

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21092N
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1985-50-10

2. JOB ORDER NO. 17575A		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C5-A			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STUD (INSERT) FOR END PLATE						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		IF THREADED END IS DAMAGED OR NOTE: CRACKED THERE IS A REPAIR TO CUT OFF AND MAKE A REPLACEMENT INSERT							
69	045	THREADED END REPAIR IF DAMAGED, CRACKED IS TO BE CUT OFF AND REPAIRED BY THE SAME MAN AND OF THE SAME MATERIAL					001 MNR 002 03 003 1001		
69	050	DRILL ALL HOLES IN FITTING AS PER 401-93-3 PARA 5-10 SUB PARA 2. *C/P MOVE					001 MNR 002 01 003 1001		
24	055	ALIGN THE END REPAIR TO BE TO THE ABOVE					001 MNR 002 01 003 1001		
69	060	LOCALLY MFG A STUD (INSERT) OF 90-100 TO STD 5-21 OF 401-93-3 USING 4130 HEAT TREATED STEEL OR EQUIVALENT *C/P MOVE					001 MNR 002 02 003 1002		
25	065	HEAT TREAT STUD (INSERT) TO 90-120 KCI IF NEEDED *C/P MOVE					001 MNR 002 03 003 1001		
25	070	REPAIR THE END OF THE STUD TO THE PLATE CRIT CRIT *C/P MOVE					001 MNR 002 01 003 1001		
25	075	LAP THE PLATE TO THE STUD *C/P MOVE					001 MNR 002 01 003 1001		
26	077	IRIDITE *C/P MOVE					001 MNR 002 02 003 1001		
25	080	100 PLATE (INITIATED BY PLATING) *C/P MOVE					001 MNR 002 03 003 1001		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21092N			
		B		D					

U.S. GOVERNMENT PRINTING OFFICE: 1980-646-103

2. ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES				11. STOCK NUMBER				12. OPTIONAL	
13. SERIAL NUMBER				14. NOUN ORIGINAL P/B LABELED					
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69	082	ALUMINUM RELATED AREAS CONTAMINATED BY PLATING) NO/P MOVE					001 0000 002 00 003 001		
69	085	MACHINE END HOLE BUSHINGS W/M MS21241-100010 NO/P MOVE					001 0000 002 00 003 002		
69	090	INSTALL END HOLE BUSHINGS DIAMETER 1.310 7505/0.7515 NO/P MOVE					001 0000 002 00 003 001		
69	095	INSTALL INSERT IN FITTING WITH ECCENTRIC HIL-S-21475 NO/P MOVE					001 0000 002 00 003 001		
69	100	IF INSERT HAS BEEN HEAT TREATED, CHASE THREADED END AFTER HEAT TREAT NO/P MOVE					001 0000 002 00 003 001		
69	100	REGRIND AND MARK POINT AND HOLE LAW 450-182 NO/P MOVE					001 0000 002 00 003 001		
69	100	FINAL POLISH ALL OF THE SURFACES MOUNTING FOR CHALLENGE AND INSPECTION OF ALL PREVIOUS OPERATIONS AND INSPECTIONS					001 0000 002 00 003 001		
69	111	FINAL PROJECT INSPECTION AND SIGN NO/P MOVE					001 0000 002 00 003 001		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21092N	
		B	D		

# WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040

1

PAGE \_\_\_ OF \_\_\_ PAGES

3. QUANTITY		4. PRODUCTION REC/CC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER 15576-1		8. TECH DATA 16G3-2-80-3 4S-1-182 AND SUPPLEMENTS				9. ITEM SERIAL NO.	
10. MODEL/DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL			
13. SERIAL NUMBER		14. BOML SCREW					
18. DISPATCH STATION	19. PERF RCC/OP NO.	17. GOVERNING DIRECTIVE/AFMCR 66-51			18. MECHANIC	19. "P"	20. "Q"
		BLAST IAW MIL-STD-1504					
		BAKE IAW 4S-1-182					
		MAOI 74-12					
		SHOTPEEN IAW MIL-S-13145					
		FPI IAW MIL-STD-6846					
		BRUSH PLATE IAW MIL-STD-845					
		FMPI IAW MIL-STD-1949					
		P/O NO1561					
		GRIND IAW MIL-STD-846					
		FLAME SPRAY IAW MIL-STD-849					
		TEMPER ETCH IAW MIL-STD-847					
		CHROME PLATE IAW MIL-STD-1501					
		TYPE II CLASS III					
		STRIP IAW MIL-STD-871					
		*****STEEL 298,000 *****					
		ALL PERSONNEL INVOLVED IN THE WORK					
		PROCESSES SPECIFIED IN THIS DOCUMENT					
		HAVE BEEN THOROUGHLY TRAINED AND ARE					
		FAMILIAR WITH ALL PERTINENT SAFETY					
		PRACTICES AND HAZARDS CONTAINED IN					
		THE BASIC TECHNICAL ORDER (T.O.) AND					
		T.O. SUPPELMENTS REFERENCED IN BLOCK					
		B OF THIS AFMCR FORM 958. THE APPLIC-					
		ABLE T.O.'S AND SUPPLEMENTS WILL					
		ALWAYS BE USED IN CONJUNCTION WITH					
		THIS DOCUMENT.					
		*COMPONENTS WILL BE THOROUGHLY					
		CLEANED & PROTECTED (C/P MOVE) FOR					
		MOVES BETWEEN OPERATIONS/DISPATCH					
		STATIONS.					
		****WARNING****					
		MANY OF THE FOLLOWING REPAIR					
		PROCEDURES REQUIRE THE USE OF					
		EQUIPMENT, PROCESSES & CHEMICALS					
		WHICH ARE POTENTIALLY DANGEROUS TO					
		PERSONNEL. ADEQUATE SAFEGUARDS AND					
		PRECAUTIONS MUST BE EMPLOYED TO					
		PRECLUDE INJURIES.					
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE			23. DOCUMENT/BN		
DISPATCH	FUNCTIONAL CODE	A	C		21065N		
		B	D				

402

21065N

89040

2

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. BOML SCREW						
15. DISPATCH STATION	16. PERM RCC/OP	17.				18. MECHANIC	19.	20.	
	OND	B-15576-1 WORK TO BE ACCOMPLISHED					"P"	"Q"	
- 34C5	005	DISASSEMBLE *C/P MOVE					001 MNP6P		
	*REQD*						002 01		
- 34C	007	CHEM CLEAN *C/P MOVE					003 SL03		
	*REQD*						001 MNP6W		
- 34B	009	BLAST CLEAN *C/P MOVE					002 03		
	*REQD*						003 SL01		
- 34B	011	BAKE 4 HRS AT 350/400F					001 MNP6W		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
							003 BK03		
- 34M	013	DATE OUT _____ TIME OUT _____ FMPI *C/P MOVE					001 MNPNA		
	*REQD*					H	002 05		
- 34Z	015	F.P.I. FOR CRACK VERIFICATION					003 HL04		
		IF REQ'D *C/P MOVE				H	001 MNPNA		
- 34E	016	E AND I					002 05		
	*REQD*	CROSS PIN HOLES 1.600/1.603/1.607					003 ZY05		
		SERVICE					001 MNP6W		
		O/S PIN HOLES 1.690/1.700 MAX					002 04		
		UPPER END O.D. 3.747/3.748/3.745					003 EI01		
		SERVICE							
		NOTE: A MINIMUM OF TWO FMPI'S							
		(CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21065N			
		B		D					

403

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. BOWL SCREW						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. ARE REQUIRED ON THIS PART.				18. MECHANIC	19. "P"	20. "Q"	
		*C/P MOVE							
26	018	VAPOR DEGREASE *C/P MOVE					001 MNPRC		
							002 03		
							003 DE01		
26	019	STRIP CHROME FROM UPPER END ONLY					001 MNPRC		
		IF REQUIRED.					002 03		
		*C/P MOVE					003 SC02		
69	021	MACHINE CENTER ON SMALL INTERNAL DIA					001 MNPRA		
		AT UPPER END .060 X 60 DEG.					002 03		
		*C/P MOVE					003 LE09		
69	022	POLISH BALL GROOVE AREA TO REMOVE					001 MNPRA		
		ROUGH AND SCORED AREAS.					002 03		
		*C/P MOVE					003 LE09		
8	025	GRIND UPPER END OF SHAFT TO 3.733MIN					001 MNPRB		
		FOR CHROME PLATE IF IT DOES NOT					002 03		
		CLEAN UP , GO TO OPERATION 030 &					003 GE06		
		INITIATE ALL APPLICABLE OPERATIONS							
		*C/P MOVE							
8	030	GRIND FOR FLAME SPRAY NOT TO EXCEED					001 MNPRB		
		3.705 MINIMUM					002 03		
		*C/P MOVE					003 GE06		
69	035	MACHINE AS REQUIRED TO REMOVE FLAME					001 MNPRA		
		SPRAY NOT TO EXCEED 3.705 MINIMUM.					002 03		
		*C/P MOVE					003 LE09		
69	040	MACHINE CROSS BOLT HOLES OVERSIZE TO					001 MNPRA		
		1.690/1.700 TO CLEANUP *NOTE REMOVE					002 03		
		ONLY ENOUGH MAT'L TO CLEAN UP					003 MV01		
		(CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A				21065N			
		B							
		C							
		D							

404

21065N

89040

4

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NAME SCREW						
15. DISPATCH STATION	16. PERP RCC/OP NO.	17. *C/P MOVE WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
26	060	NITAL ETCH 1					001 MNPNA		
		TIME OUT _____ DATE OUT _____					002 08		
		*C/P MOVE					003 TB03		
		* * * * * N O T E * * * * *							
		IF LAST NDI OPERATION IS COMPLETED*							
		HERE, TAKE PRODUCTION COUNT *							
26B	070	BAKE 4 HRS AT 350/400F WITHIN 8 HRS					001 MNPNA		
		OF ETCH					002 03		
		DATE IN _____ TIME IN _____					003 BK01		
		DATE OUT _____ TIME OUT _____							
8A	080	*C/P MOVE					001 MNPNA		
		FMPI					002 08		
		* * * * * N O T E * * * * *					003 ML04		
		IF LAST NDI OPERATION IS COMPLETED*							
		HERE, TAKE PRODUCTION COUNT *							
		* * * * * N O T E * * * * *							
26	085	VAPOR DEGREASE					001 MNPNA		
		*C/P MOVE					002 03		
							003 DG01		
26	090	SHOTPEEN REWORKED AREAS .012/.016					001 MNPNA		
		*C/P MOVE					002 03		
							003 SF02		
69	091	MACHINE CROSS PIN BUSHING FOR							
		FLAMESPRAY. P/N 66C33001-107ST.							
		*C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21065N			
		B		D					

405



# WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 1 OF 1 PAGES

21065N

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER		12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN						
			BALL SCREW						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
69	092	INSTALL BUSHING FOR FLAMESPRAY ONLY WITH 0.003-0.004 INCH INTERFERENCE FIT. *C/P MOVE							
26	096	PREPARE O.D. FOR CHROME PLATE TYPE II CLASS 3 MASK/FIXTURE/ETC. *MECHANIC SIGN OFF REQUIRED *C/P MOVE					001 MNPRC 002 02 003 BE01		
26	098	PREPARE O.D. FOR CHROME PLATE, GRIT BLAST *C/P MOVE					001 MNPRC 002 01 003 BL02		
26	100	CHROME PLATE O.D. TYPE II CLASS 3 SUFFICIENT TO GRIND BACK TO 3.748 DATE OUT _____ TIME OUT _____ *MECHANIC SIGN OFF REQUIRED-----> *C/P MOVE					001 MNPRC 002 02 003 CR01 008 CR010		
26B	110	BAKE 23 HRS AT 350/400F WITHIN 4 HRS OF CHROME DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
8	120	FINISH GRIND TO 3.747/3.748 WITH 32 RMS *C/P MOVE					001 MNPRB 002 03 003 GE06		
26B	130	BAKE 4 HRS AT 350/400F DATE IN _____ TIME IN _____					001 MNPRC 002 02 003 BK01		

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT T/SN	
DISPATCH	FUNCTIONAL CODE	A	C	21065N	
		B	D		

406

## 21065N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040

PAGE 6 OF 6 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN BALL SCREW						
18. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
8A	140	FMPI , *C/P MOVE  ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****				M	001 MNPNA 002 06 003 ML04		
26	145	VAPOR DEGREASE *C/P MOVE					001 MNPRC 002 03 003 DG01		
26A	150	FPI , *C/P MOVE  ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *****				M	001 MNPNA 002 06 003 ZS01		
25B	152	VAPOR DEGREASE, PRIOR TO FLAME SPRAY *C/P MOVE					001 MNPWW 002 06 003 DG01		
25B	154	MASK, PRIOR TO FLAME SPRAY *C/P MOVE					001 MNPWW 002 06 003 BE01		
25B	156	GRIT BLAST, PRIOR TO FLAME SPRAY *C/P MOVE					001 MNPWW 002 06 003 BL01		
25B	160	FLAME SPRAY .004/.007 USING METCO 405 BOND COAT & BUILDUP WITH METCO #5 STAINLESS AS REQUIRED TO MACHINE (CONTINUED)					001 MNPWW 002 06 003 F908 005 XF929451		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21065N			
		B		D					

407

## 21065N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 7 OF 7 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN BALL SCREW						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		BACK TO 3.765 *C/P MOVE							
25B	164	UNMASK AND CLEAN OVER SPRAY *C/P MOVE					001 MNPWW 002 08 003 FS08		
25B	166	SEAL FLAME SPRAY *C/P MOVE					001 MNPWW 002 08 003 FS08		
69	170	ROUGH MACHINE FLAME SPRAY TO 3.765 *C/P MOVE					001 MNPRA 002 02 003 LE06		
69	173	CLEAN UP CROSS PIN HOLES AFTER FLAME SPRAY *C/P MOVE					001 MNPRA 002 02 003 MV01		
8	175	FINISH GRIND FLAMESPRAY 3.747/3.748. MAINTAIN 64RMS FINISH AFTER GRIND. BLEND TAPERED AREA TO MAINTAIN 1.50 RAD. CHAMFER TOP END 20DEG. BY 200 *C/P MOVE					001 MNPRA 002 03 003 GE06		
69	178	BRUSH LHE CAD CHROME/FLAME SPRAY FADE OUT AREA (TAPERED END) IF REQUIRED. *C/P MOVE					001 MNPRA 002 02 003 BE01		
69	190	MACHINE CROSS PIN BUSHING P/N 66C33001-107ST, *C/P MOVE					001 MNPRA 002 02 003 MV05		
69	191	INSTALL/FINISH BUSHING I.D. 1.600- 1.603. 0.003-0.004 INTERFERENCE FIT. *C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21065N			
		B		D					

## 21065N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89040

PAGE 8 OF 8 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN BALL SCREW						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
34P	200	PRE-PAINT I.D. OF BALL SCREW *C/P MOVE					001 MNP GP		
							002 09		
							003 PR 01		
34C5	210	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958					001 MNP GP		
							002 01		
							003 ML 06		
34C5	220	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE *REQD*					001 MNP GP		
							002 01		
							003 ML 06		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21065N			
		B		D					

409

17575A CSA MLG 4611020-107A

RCC MNPRA

451-93-3

84013

H S S W F PF A/R REV

STEP	D L	K C	DC	ELEMENT	OCC FACT	DESCRIPTION	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
0001	S E	JA	EA	1 J 88305	.79	PERCENT ENGR 99.8	33.68		26.61	
0001		JA	01	00	.00	MACHINE CSA OUTER CYL. PART NUMBER/NSN	.000	.000	.000	0
0010						4611415-107A 1620004463776				
0120		JA	01	15	.16	2ND REPAIR AREA C	3.398	.082	.625	2
0010 E				KHM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTMPORATE OVER 4 PARTS	.50518		.145	
0020 E				RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098	
0030 E				RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E				KHM-BD-LB	4.00	BORE HOLE 6 X 1 GROUP 4	.74190		3.412	
0060 E				RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	.00601		.006	
0070 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0121		JA	01	15	.16	CHECK & RECORD DIM.	.741	.018	.136	0
0010 E				KHM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTMPORATE OVER 4 PARTS	.50518		.145	
0020 E				RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098	
0030 E				RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 N					1.00	CHECK & RECORD DIM.	.31700		.364	
0060 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0125		JA	01	15	.16	REPAIR COLLAR AREA	2.446	.059	.450	1
0010 E				KHM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTMPORATE OVER 4 PARTS	.50518		.145	
0020 E				RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098	
0030 E				RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E				RML-BD-HD	2.00	BORE HOLE 4.5 X 2 GROUP 4	1.00775		2.317	
0060 E				RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION RECORD BASE METAL DIM.	.00601		.006	
0070 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0130		JA	01	15	.16	REPAIR COLLAR FACE	1.316	.032	.242	1
0010 E				KHM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTMPORATE OVER 4 PARTS	.50518		.145	
0020 E				RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098	
0030 E				RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E				KML-FR-JA	2.00	FACE ROUGH 5-6 DIA. GROUP 1 2 PASSES	.42654		.981	
0060 E				KML-FF-JA	1.00	FACE FINISH 5 TO 6 GROUP 1	.03259		.037	
0070 E				RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION RECORD FLANGE THICKNESS	.00601		.006	
0080 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0135		JA	01	15	.21	MACHINE SHOULDER	1.326	.042	.320	1
0010 E				KHM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTMPORATE OVER 4 PARTS	.50518		.145	
0020 E				RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098	
0030 E				RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E				RML-BD-JA	2.00	BORE HOLE 5 X 1/2 GROUP 4	.44802		1.030	
0060 E				RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION RECORD WASHER THICKNESS	.00601		.006	
0070 E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0140		JA	01	15	.42	REP BALLSCREW HOLE RGT SIDE	5.030	.317	2.430	7
0010 E				KHM-SU-V1	.25	S/U VERT MILL BORE SMAL FXTMPORATE OVER 4 PARTS	.50518		.145	
0020 E				RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098	
0030 E				RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E				RML-BD-GH	2.00	BORE HOLE 4 X 6 GROUP 4	2.28979		5.289	

0060 E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	.00601	.006	
0070 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0 E	JA 01	15	.42 REP BALLSCREW HOLE LFT SIDE	.646	.041	.312 1
0020 E	KHM-SU-V1	.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS	.50518	.145	
0030 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531	.098	
0040 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699	.146	
0050 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0060 E	RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE	.21626	.248	
0070 E	RJP-PW-C1	1.00	WRITE CRITICAL DIMENSION	.00601	.006	
0150	JA 01	15	.32 O/S HOLE ON MILL/SMALL PART	.01001	.011	
0010 E	KHM-SU-V1	.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS	.915	.044	.337 1
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.50518	.145	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.08531	.098	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.12699	.146	
0050 E	RML-BD-LA	1.00	BORE HOLE 6 X 1/2 GROUP 4	.07609	.087	
0060 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.49100	.564	
0155	JA 01	15	.32 O/S HOLE ON MILL/SMALL PART	.01001	.011	
0010 E	KHM-SU-V1	.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS	.640	.031	.236 1
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.50518	.145	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.08531	.098	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.12699	.146	
0050 E	RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE	.07609	.087	
0060 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.21626	.248	
0160	JA 01	15	.16 OVERSIZE HOLE WITH REAMER	.01001	.011	
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.349	.008	.064 0
0020 E	RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.18669	.053	
0030 E	RBW-SU-R2	3.00	REAM WITH LEMPCO REAMER 3 PASSES	.06831	.078	
0040 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.07337	.253	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.00423	.004	
0165	JA 01	15	.16 OVERSIZE HOLE WITH REAMER	.01001	.011	
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.349	.008	.064 0
0020 E	RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND	.18669	.053	
0030 E	RBW-SU-R2	3.00	REAM WITH LEMPCO REAMER 3 PASSES	.06831	.078	
0040 E	RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES	.07337	.253	
0050 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.00423	.004	
0170	JA 01	15	.16 O/S HOLE ON MILL/SMALL PART	.01001	.011	
0010 E	KHM-SU-V1	.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS	1.083	.026	.199 1
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.50518	.145	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.08531	.098	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.12699	.146	
0050 E	RML-BD-DD	1.00	BORE HOLE 2.5 X 2 GROUP 4	.07609	.087	
0060 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.65881	.757	
0175	JA 01	15	.27 O/S HOLE ON MILL/SMALL PART	.01001	.011	
0010 E	KHM-SU-V1	.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS	.640	.026	.199 1
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.50518	.145	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.08531	.098	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.12699	.146	
0050 E	RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE	.07609	.087	
0060 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.21626	.248	
0180	JA 01	15	.05 O/S HOLE ON MILL/SMALL PART	.01001	.011	
0010 E	KHM-SU-V1	.25	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS	.640	.005	.037 0
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.50518	.145	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.08531	.098	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.12699	.146	
0050 E	RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE	.07609	.087	
0060 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.21626	.248	

0060 E	RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001	.011	
0190 JA 01 15		.11	O/S HOLE ON MILL/SMALL PART	.640	.011	.081 0
0010 E	KMM-SU-V1	.25	S/U VERT MILL BORE SMAL EXTRPRORATE OVER 4 PARTS	.50518		.145
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087
0050 E	RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE	.21626		.248
0060 E	RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.011
0205 JA 01 15		.05	LOCATE & DRILL 1 HOLE	.150	.001	.009 0
0010 E	KML-CD-P1	1.00	CENTER DRILL	.01519		.017
0020 E	RSG-JP-03	1.00	PREP HAND DRILL FOR USE	.00861		.009
0030 E	RLA-DR-CA	3.00	DRILL HOLE 1/8-1/4 DIA ( 1/2	.03903		.134
0040 E	RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.011
0210 JA 01 15		.05	O/S HOLE ON MILL/SMALL PART	.793	.006	.046 0
0010 E	KMM-SU-V1	.25	S/U VERT MILL BORE SMAL EXTRPRORATE OVER 4 PARTS	.50518		.145
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146
0040 E	RML-AL-AC	3.00	ALIGN HOLE TO SPINDLE ROD OCC. FOR 3 HOLES	.07609		.262
0050 E	RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1 USE PROPER ELEMENT/TABLE	.21626		.248
0060 E	RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.011
0408 JA 01 15		.83	TURN BUSHING GROUP 4/STEEL	1.750	.218	1.671 5
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.011
0030 E	KML-TD-JC	1.00	DIA 5.00-6.00 REM .033-.250	.40208		.462
0040 E	KML-TD-JD	5.00	DIA 6.00 REM .250 ADD INCH	.24071		1.384
0050 E	RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.011
0410 JA 01 15		.83	INST SET FLANGED BUSHINGS	.082	.010	.079 0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053
0020 E	RBW-BU-A1	.50	INSTALL SET FLANGED BUSHINGS NO POLISH	.05133		.029
0030 E	RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.011
0410 JA 01 15		1.00	O/S HOLE ON MILL/SMALL PART	.915	.137	1.353 3
0010 E	KMM-SU-V1	.25	S/U VERT MILL BORE SMAL EXTRPRORATE OVER 4 PARTS	.50518		.145
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087
0050 E	RML-BD-LA	1.00	BORE HOLE 6 X 1/2 GROUP 4	.49100		.564
0060 E	RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.011
0418 JA 01 15		1.00	TURN BUSHING GROUP 1/BRONZE	.314	.047	.362 1
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.011
0030 E	KML-TA-HC	2.00	DIA 4.00-5.00 REM .033-.250	.08497		.195
0040 E	RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.011
0419 JA 01 15		1.00	INST STRAIGHT BUSH NO POLISH	.077	.012	.089 0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062		.023
0030 E	RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.011
0420 JA 01 15		1.00	TURN BUSHING GROUP 1/BRONZE	.327	.049	.377 1
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143
0020 E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.023
0030 E	KML-TA-HC	1.00	DIA 4.00-5.00 REM .033-.250	.08497		.097
0040 E	KML-TA-HD	4.00	DIA 5.0 REM .250 ADD INCH	.02185		.100
0050 E	RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.011
0421 JA 01 15		1.00	INST SET FLANGED BUSHINGS	.082	.012	.095 0
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053
0020 E	RBW-BU-A1	.50	INSTALL SET FLANGED BUSHINGS NO POLISH	.05133		.029
0030 E	RJP-PW-R1	1.00	REM RPL PAPMRK SIGN OFF DOC	.01001		.011

0422	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.289	.043	.332	1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.01006		.023	
0030 E		KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0423	JA 01	15	1.00	INST SET FLANGED BUSHINGS	.108	.016	.124	0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	1.00	INSTALL SET FLANGED BUSHINGS NO POLISH	.05133		.059	
0030 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0424	JA 01	15	1.00	O/S HOLE ON MILL/SMALL PART	1.145	.172	1.317	4
0010 E		KMH-SU-V1	.25	S/U VERT MILL BORE SHAL EXTRPRORATE OVER 4 PARTS	.50518		.145	
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E		RML-BC-BD	2.00	BORE HOLE 1.5 X 2 GROUP 3 OCC. FOR 2 HOLES	.36029		.828	
0060 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0426	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.289	.043	.332	1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK 2 BUSHINGS	.01006		.023	
0030 E		KML-TA-EC	2.00	DIA 1.50-2.00 REM .033-.250	.06699		.154	
0040 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0427	JA 01	15	1.00	INST SET FLANGED BUSHINGS	.108	.016	.124	0
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	1.00	INSTALL SET FLANGED BUSHINGS NO POLISH	.05133		.059	
0030 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0428	JA 01	15	1.00	O/S HOLE ON MILL/SMALL PART	1.145	.172	1.317	4
0010 E		KMH-SU-V1	.25	S/U VERT MILL BORE SHAL EXTRPRORATE OVER 4 PARTS	.50518		.145	
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E		RML-BC-BD	2.00	BORE HOLE 1.5 X 2 GROUP 3 OCC. FOR 2 HOLES	.36029		.828	
0060 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0431	JA 01	15	1.00	O/S HOLE ON MILL/SMALL PART	1.569	.235	1.804	5
0010 E		KMH-SU-V1	.25	S/U VERT MILL BORE SHAL EXTRPRORATE OVER 4 PARTS	.50518		.145	
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E		RML-BA-CD	1.00	BORE HOLE 2 X 2 GROUP 1	1.14431		1.315	
0060 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0432	JA 01	15	1.00	O/S HOLE ON MILL/SMALL PART	1.153	.173	1.327	4
0010 E		KMH-SU-V1	.25	S/U VERT MILL BORE SHAL EXTRPRORATE OVER 4 PARTS	.50518		.145	
0020 E		RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098	
0030 E		RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699		.146	
0040 E		RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0050 E		RML-BC-LA	2.00	BORE HOLE 6 X 1/2 GROUP 3 OCC. FOR 2 HOLES	.36440		.838	
0060 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0433	JA 01	15	1.00	CHECK AND RECORD DIMENSIONS	1.015	.152	1.167	3
0010 E		RML-SU-V3	.25	S/U VERT MIL BORE FXTR HOIST:PRORATE OVER FOUR PARTS	1.03687		.298	
0020 E		KMH-HP-CD	1.00	HOIST HANDLE WRAPPED 2 CLAMP:	.14995		.172	
0030 E		KMH-AL-AA	1.00	ALIGN HORIZ AXIS ROD	.05266		.060	
0040 E		KMH-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.14457		.166	
0050 E		KMH-AL-AA	7.00	ALIGN HORIZ AXIS ROD ; PICH UP SURFACE/ 7 EACH	.05266		.423	
0060 E		RJP-PW-C1	5.00	WRITE CRITICAL DIMENSION ; FIVE EACH DIMENSIONS	.00601		.034	
0070 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC:	.01001		.011	
0434	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.630	.095	.725	2
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	



0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.011	
0030 E	KML-TA-GC	6.00	DIA 3.00-4.00 REM .033-.250	.07800	.538	
0040 E	KML-TA-GD	1.00	DIA 4.0 REM .250 ADD INCH	.01707	.019	
0 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
JA 01	15	1.00	INST SET FLANGED BUSHINGS	.082	.012	.095
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-A1	.50	INSTALL SET FLANGED BUSHINGS NO POLISH	.05133	.029	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0471	JA 01	15	1.00 O/S HOLE ON MILL/SMALL PART	1.881	.282	2.164
0010 E	KMM-SU-V1	.25	S/U VERT MILL BORE SMAL EXTRPRORATE OVER 4 PARTS	.50518	.145	
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531	.098	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699	.146	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0050 E	RML-BC-GM	1.00	BORE HOLE 4 X 6 GROUP 3	1.45667	1.675	
0060 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0474	JA 01	15	1.00 TURN BUSHING GROUP 1/BRONZE	.314	.047	.362
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.011	
0030 E	KML-TA-HC	2.00	DIA 4.00-5.00 REM .033-.250 2 PASSES	.08497	.195	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0475	JA 01	15	1.00 INST STRAIGHT BUSH NO POLISH	.077	.012	.089
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0476	JA 01	15	1.00 O/S HOLE ON MILL/SMALL PART	1.881	.282	2.164
0010 E	KMM-SU-V1	.25	S/U VERT MILL BORE SMAL EXTRPRORATE OVER 4 PARTS	.50518	.145	
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531	.098	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699	.146	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0050 E	RML-BC-GM	1.00	BORE HOLE 4 X 6 GROUP 3	1.45667	1.675	
0060 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0478	JA 01	15	1.00 TURN BUSHING GROUP 4/STEEL	.409	.061	.471
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK OCC. FOR 2 BUSHINGS	.01006	.023	
0030 E	KML-TD-EC	1.00	DIA 1.50-2.00 REM .033-.250	.17225	.198	
0040 E	KML-TD-ED	1.00	DIA 2.00 REM .250 ADD INCH	.08233	.094	
0050 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0480	JA 01	15	1.00 INST/REAM SET STRAIGHT BUSH	.278	.042	.321
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.22231	.255	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0484	JA 01	15	1.00 TURN BUSHING GROUP 4/STEEL	.409	.061	.471
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK	.01006	.023	
0030 E	KML-TD-EC	1.00	DIA 1.50-2.00 REM .033-.250	.17225	.198	
0040 E	KML-TD-ED	1.00	DIA 2.00 REM .250 ADD INCH	.08233	.094	
0050 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0485	JA 01	15	1.00 INST/REAM SET STRAIGHT BUSH	.278	.042	.321
0010 E	RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669	.053	
0020 E	RBW-BU-B2	1.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.22231	.255	
0030 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	
0488	JA 01	15	1.00 TURN BUSHING GROUP 1/BRONZE	.222	.033	.255
0010 E	RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962	.143	
0020 E	RLA-HP-C1	2.00	1ST PART IN-OUT SCROLL CHUCK OCC. 2 BUSH.	.01006	.023	
0030 E	KML-TA-EC	1.00	DIA 1.50-2.00 REM .033-.250	.06699	.077	
0040 E	RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC	.01001	.011	

0500	JA 01	15	1.00	INST SET FLANGED BUSHINGS	.082	.012	.095	0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	.50 INSTALL SET FLANGED BUSHINGS NO POLISH		.05133		.029	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	1.00	O/S HOLE ON MILL/SMALL PART	1.040	.156	1.196	4
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SHAL FTRPRORATE OVER 4 PARTS		.50518		.145	
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RML-BC-CB	2.00 BORE HOLE 2 X 1 GROUP 3	OCC. 2 HOLES	.30779		.707	
0060 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0504	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.289	.043	.332	1
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK	OCC. FOR 2 BUSH.	.01006		.023	
0030 E		KML-TA-EC	2.00 DIA 1.50-2.00 REM .033-.250	OCC. FOR 2 BUSH.	.06699		.154	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0505	JA 01	15	1.00	INST STRAIGHT BUSH NO POLISH	.097	.015	.113	0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	2.00 INSTALL ONE STRAIGHT BUSHING	OCC. FOR 2 BUSH.	.02062		.047	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0507	JA 01	15	1.00	INST/REAM SET STRAIGHT BUSH	.278	.042	.321	1
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B2	1.00 REBUSH A SET OF 2 BOSSES	INCLUDES REAM & POLISH	.22231		.255	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0509	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.222	.033	.255	1
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	2.00 1ST PART IN-OUT SCROLL CHUCK	OCC. FOR 2 BUSH.	.01006		.023	
0030 E		KML-TA-EC	1.00 DIA 1.50-2.00 REM .033-.250		.06699		.077	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
	JA 01	15	1.00	INST SET FLANGED BUSHINGS	.082	.012	.095	0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A1	.50 INSTALL SET FLANGED BUSHINGS NO POLISH		.05133		.029	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0512	JA 01	15	1.00	O/S HOLE ON MILL/SMALL PART	1.381	.282	2.164	6
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SHAL FTRPRORATE OVER 4 PARTS		.50518		.145	
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RML-BC-GM	1.00 BORE HOLE 4 X 6 GROUP 3		1.45667		1.675	
0060 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0514	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.211	.032	.244	1
0010 E		RLA-SU-S3	.25 SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	1.00 1ST PART IN-OUT SCROLL CHUCK		.01006		.011	
0030 E		KML-TA-EC	1.00 DIA 1.50-2.00 REM .033-.250		.06699		.077	
0040 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0515	JA 01	15	1.00	INST STRAIGHT BUSH NO POLISH	.077	.012	.089	0
0010 E		RBW-BU-S1	.25 SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-A4	1.00 INSTALL ONE STRAIGHT BUSHING		.02062		.023	
0030 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0516	JA 01	15	1.00	O/S HOLE ON MILL/SMALL PART	1.981	.282	2.164	6
0010 E		KMM-SU-V1	.25 S/U VERT MILL BORE SHAL FTRPRORATE OVER 4 PARTS		.50518		.145	
0020 E		RML-HP-CA	1.00 HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E		RML-AL-AB	1.00 ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E		RML-AL-AC	1.00 ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E		RML-BC-GM	1.00 BORE HOLE 4 X 6 GROUP 3		1.45667		1.675	
0060 E		RJP-PW-R1	1.00 REM RPL PAPWRK SIGN OFF DOC		.01001		.011	

0519	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.345	.052	.398	1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK	.01006		.011	
0030 E		KML-TA-CC	3.00	DIA .501-1.00 REM .033-.250	.06699		.231	
0040 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0520	JA 01	15	1.00	INST/REAM SET FLANGED BUSH	.771	.116	.887	3
0010 E		RBW-BU-S1	.25	SET UP TO REBUSH BOSSES PRORATE OVER 4 PARTS	.18669		.053	
0020 E		RBW-BU-B1	3.00	REBUSH A SET OF 2 BOSSES INCLUDES REAM & POLISH	.23835		.822	
0030 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0524	JA 01	15	1.00	TURN BUSHING GROUP 1/BRONZE	.366	.055	.421	1
0010 E		RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE PRORATE OVER 4 PARTS	.49962		.143	
0020 E		RLA-HP-C1	3.00	1ST PART IN-OUT SCROLL CHUCK OCC. FOR 3 BUSHINGS	.01006		.034	
0030 E		KML-TA-CC	3.00	DIA .501-1.00 REM .033-.250 OCC. FOR 3 BUSHINGS	.06699		.231	
0040 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
0525	JA 01	15	1.00	POLISH I.D.	.104	.016	.120	0
0010 E		RBW-BU-A4	3.00	INSTALL ONE STRAIGHT BUSHING OCC. FOR 3 BUSHINGS	.01603		.055	
0020 E		RSG-JP-05	1.00	PREP HAND DRILL CHANGE 1 BIT	.01603		.018	
0030 E		RBW-BU-P1	3.00	BUTTERFLY POLISH BUSHING I D OCC. 3 BUSHINGS	.01001		.034	
0040 E		RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001		.011	
9000	JA 01	00	.00	LABOR STANDARD HISTORY	.000	.000	.000	0
0010				9 JUNE 88 INITIAL INPUT MRPII				
0900				NED MONROE MANEL 73255 MR BIG				

TO INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

02/15/89

A-E046B-MM1-DY-M45 PAGE 0001

17575A CSA MLG 4611020-107A

RCC MNPRA

4S1-93-3

84013

STEP		DL		K C DC ELEMENT		FACT		STORED		DESCRIPTION		SUPPLEMENTAL		BASE		PFD		STD		A	
														HOURS		TIME		HOURS		DLY PCT C	
A007	S	E	JA	EA	1	J	88277	.25	PERCENT	ENGR	99.9	MACH C-5A MLG SPLINED TUBE		.04				.01			
0001			JA	01	00			.00				PART NUMBER / NSN		.000		.000		.000		0	
	0010									4613413-101A	NSL										
0050			JA	01	15			.05				RECENTER PIN--60--		.721		.005		.042		90	
	0010	E				RLA-SU-S3	1.00	SET UP	SMALL	MEDIUM	LATHE	PRORATE 2 PARTS		.49962				.574			
	0020	E				RLA-HP-C3	2.00	CHUCK	SYNET	PART	IN 4 JAW	BOTH SIDES		.09095				.209			
	0030	E				KML-CD-P1	2.00	CENTER	DRILL					.01519				.034			
	0050	E				RJP-PW-R1	1.00	REM RPL	PAPWRK	SIGN	OFF DOC			.01001				.011			
0060			JA	01	15			.05				NICK AND BURR MEDIUM PART		.077		.001		.004		10	
	0010	E				RLG-RS-N3	1.00	NICK &	BURR	MED	STRUT PART			.06711				.077			
	0020	E				RJP-PW-R1	1.00	REM RPL	PAPWRK	SIGN	OFF DOC			.01001				.011			
9000			JA	01	15			.01				LABOR STD HISTORY		.000		.000		.000		0	
	0010									23JUN83	OCC FACTOR	CHG AVG 3 STUDIES									
	0020											PREVIOUS STD HRS 0.62									
	0030									27AUG85	UPDATE	OCCURANCE FACTORS/RESTRUCTURED									
	0031											LABOR STANDARD TO MATCH AFLC FORM 958									
	0032											WORK PREVIOUSLY DONE ON OPERATION 80170									
	0033											OLD STANDARD .57 HOURS									
	0900											N MONROE MANEAA 73357									

GATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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## LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

04/21/89

A-E046B-MM1-DY-W45 PAGE 0001

17575A CSA MLG 4G11020-107A

RCC NNPA

4S1-93-3

84013

JPEP CH S S W F PF A/R REV

STEP	D L	K C	DC	ELEMENT	FACT	STORED	DESCRIPTION	SUPPLEMENTAL	BASE HOURS	PFD TIME	STD HOURS	A DLY PCT C
RA002	S	E	JA	EA 1	J 88280	.67	PERCENT ENGR 99.9	CSA INNER CYL	22.12		14.82	
0001			JA	01	00	1.00		PART NUMBER/MSN	.000	.000	.000	0
							4G11414-107A	1620004176249				
0050			JA	01	15	.50		LARGE ATT LUG REPAIR	6.021	.452	3.463	16
0010	E				KMM-SU-V1	1.00	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS		.50518		.580	
0020	E				RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030	E				RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E				RML-BD-JG	3.00	BORE HOLE 5 X 3 1/2 GROUP 4		1.73940		6.000	
0060	E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0060			JA	01	15	.38		SMALL ATT LUG REPAIR	3.851	.220	1.683	8
0010	E				KMM-SU-V1	1.00	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS		.50518		.580	
0020	E				RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030	E				RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E				RML-BD-LE	2.00	BORE HOLE 6 X 2 1/2 GROUP 4		1.52384		3.504	
0060	E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0070			JA	01	15	.63		REP SMALL LUG FACE	2.051	.194	1.486	7
0010	E				RML-SU-V3	1.00	S/U VERT MIL BORE FTR HOIST LUCAS BORING MILL		1.03687		1.192	
0020	E				RML-AL-CA	1.00	ALIGN HORIZ AXIS MAG BASE		.05917		.068	
0030	E				RML-AL-CB	1.00	ALIGN VERTICAL AXIS MAG BASE		.12351		.142	
0040	E				RML-AL-CC	1.00	ALIGN HOLE TO SPINDLE MAG BS		.07261		.083	
0050	E				RML-BD-LB	1.00	BORE HOLE 6 X 1 GROUP 4	ELEMENT FOR FACE ON MILL	.74921		.861	
							NOT AVAILABLE. USED BORING					
							ELEMENT INSTEAD OF ESTIMATE.					
0070	E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0080			JA	01	15	.05		POSITIONER LUG REPAIR	.489	.004	.028	0
0010	E				RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.214	
0020	E				RLG-HP-V7	1.00	OBJ IN/OUT STP VISE-HST HAND		.06831		.078	
0030	E				RBW-BU-R2	3.00	REAM WITH LEMCO REAMER	3 PASSES	.07337		.253	
0040	E				RBW-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004	
0050	E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0090			JA	01	15	.19		2ND METERING PIN REPAIR	2.130	.061	.465	2
0010	E				KMM-SU-V1	1.00	S/U VERT MILL BORE SMAL FTRPRORATE OVER 4 PARTS		.50518		.580	
0020	E				RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030	E				RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E				RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050	E				RML-BD-JB	2.00	BORE HOLE 5 X 1 GROUP 4		.66325		1.525	
0060	E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
0509			JA	01	15	1.00		ODMACH METER PIN BUSH	1.283	.192	1.476	7
0010	E				RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE		.49962		.574	
0020	E				KML-TD-JA	1.00	DIA 5.00-6.00 REM (.033	FLANGE	.26581		.305	
0030	E				KML-TD-JB	1.00	DIA 6.00 REM .033 ADD INCH	FLANGE	.16047		.184	
0040	E				KML-TD-HA	1.00	DIA 4.00-5.00 REM (.033	OD	.22607		.259	
0050	E				RLA-RC-KA	1.00	RECESS 4.5-5 DIA. 1/8 DP G1		.04514		.051	
0060	E				RLA-FF-LG	1.00	FACE FINISH 7 - 8 GROUP 4		.07619		.087	
0140	E				RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC		.01001		.011	
			JA	01	15	1.00		MFG/INST METER PIN BUSH	.223	.034	.258	1
0	E				RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES		.18669		.214	

0110 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0120 E	RBW-BU-P1	2.00	BUTTERFLY POLISH BUSHING 1 DADDITIONAL POLISH REQ'D	.00333	.007	
0140 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
JA 01 15		1.00	MACH LARGE ATTACH BUSHINGS	3.172	.476	3.648 16
0110 E	RLA-SU-S3	.50	SET UP SMALL MEDIUM LATHE 1 S/U PER LGE & SML	.49962	.287	
0020 E	RML-HP-CC	1.00	HOIST HANDLE NO WRAP 2 CLAMPPLACE FIXTURE IN LATHE	.15776	.181	
0030 E	RLA-HP-C4	3.00	IRREG PART IN 4 JAW CHUCK OCC TO DIAL FACE AND	.22097	.762	
0031			O.D. WITH IN .001			
0040 E	RLA-PT-DJ115.00		MACH TIME 60 SFPM .004 FEED OCC FACTOR BASED ON LXDNUMB	.01819	2.405	
0041			OF CUTS 10.5 X 7.5 X 3			
0150 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0540 JA 01 15		1.00	INST LRGE ATTACH BUSHING	.123	.018	.142 1
0050 E	RBW-BU-S1	.50	SET UP TO REBUSH BOSSES PRORATED OVER 2 HOLES	.18517	.106	
0060 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0150 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0542 JA 01 15		1.00	MACHINE FINISH LARGE ATT	3.299	.495	3.794 17
0010 E	KMM-SU-V1	1.00	S/U VERT MILL BORE SML EXTRPRORATE OVER 4 PARTS	.50518	.580	
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531	.098	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699	.146	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0050 E	RML-BC-JH	2.00	BORE HOLE 5 X 4 GROUP 3 USE PROPER ELEMENT/TABLE	1.24799	2.870	
0060 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0548 JA 01 15		1.00	MACH SMALL ATTACH BUSHINGS	.895	.134	1.029 5
0010 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE 1 S/U PER LGE & SML	.49962	.574	
0020 E	KML-TC-JC	1.00	DIA 5.00-6.00 REM .033-.250	.24985	.287	
0030 E	KML-TC-JD	1.00	DIA 6.0 REM .250 ADD INCH	.13553	.155	
0150 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0550 JA 01 15		1.00	INST SMALL ATTACH BUSHING	.123	.018	.142 1
0010			A			
040 E	RBW-BU-S1	.50	SET UP TO REBUSH BOSSES PRORATED OVER 2 HOLES	.18517	.106	
0050 E	RBW-BU-A4	1.00	INSTALL ONE STRAIGHT BUSHING	.02062	.023	
0150 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0551 JA 01 15		1.00	MACHINE SMALL ATT	1.958	.294	2.252 10
0010 E	KMM-SU-V1	1.00	S/U VERT MILL BORE SML EXTRPRORATE OVER 4 PARTS	.50518	.580	
0020 E	RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS	.08531	.098	
0030 E	RML-AL-AB	1.00	ALIGN VERTICAL AXIS ROD	.12699	.146	
0040 E	RML-AL-AC	1.00	ALIGN HOLE TO SPINDLE ROD	.07609	.087	
0050 E	RML-BC-LF	1.00	BORE HOLE 6 X 3 GROUP 3	1.15457	1.327	
0060 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0559 JA 01 15		1.00	MACH POSITIONER BUSHINGS	1.324	.199	1.523 7
0010 E	RLA-SU-S3	1.00	SET UP SMALL MEDIUM LATHE FOR 4 BUSHINGS	.49962	.574	
0020 E	KML-TC-CA	4.00	DIA .501-1.00 REM (.033	.06381	.293	
0030 E	RLA-BO-BE	4.00	BORE HOLE 1/2 TO 1 DIA 1 DP	.10497	.482	
0040 E	RLA-BO-BE	4.00	CUT OFF 1/2 - 1 DIA. GROUP 3	.03486	.160	
0080 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
0560 JA 01 15		1.00	INST POSITIONER BUSHINGS	.641	.096	.738 3
0050 E	RBW-BU-S1	1.00	SET UP TO REBUSH BOSSES	.18669	.214	
0060 E	RBW-BU-B2	2.00	REBUSH A SET OF 2 BOSSES 2 SETS OF 2	.22231	.511	
0080 E	RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC	.01001	.011	
9000 JA 01 15		.00	LABOR STANDARD HISTORY	.000	.000	.000 0
0010			27AUG85 UPDATED OCCURANCE FACTORS/RESTRUCTURED			
0011			LABOR STD TO MATCH AFLC FORM 958			
0012			<OLD STANDARD> 17.36			
0020			28JAN86 UPDATED OCC FACTORS <OLD STD> 20.26			
0030			04FEB86 CHANGED SUB-OP 0560, 0570, 0580 TO SUB-OP			
131			0540, 0550, AND 0560 TO MATCH UPDATED AFLC			

0032  
0900

958/ NO TIME CHANGE  
N MONROE MANEAA 73357

TU INTERROGATE LABOR STANDARDS. INPUT

RCC PRD NROP NR

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## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED		
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN							
			GEAR DRIVE HINGING ASSY							
15. DISPATCH STATION		16. PERP RCC/OP NO.		17. MATCH-UP WORK TO BE ACCOMPLISHED			18. MECHANIC		19. 001 MNR 002 01	
				NEW/SERVICEABLE REQUIRED NO REQD					003 MNR 6	
				UPPER PLATE 21012N						
				LOWER PLATE 21012K						
		015		PRESS/INSPECTION OF ALL MOUNTED ITEMS TO INSURE THAT ALL PARTS ARE					001 MNR 0P 002 01	
		*REQD*		OPERATIONS ON JOBS HAVE BEEN OK BEFORE ASSY OF THE CHAIN DRIVE ROLLING ASSY.					003 MNR 6	
		020		PRESS TOGETHER DRIVE SPROCKET, SPACER, NEEDLE AND BEARING INTO ONE					001 MNR 0P 002 01	
		*REQD*		SPROCKET AND IN THIS ASSEMBLY PRESS IN NEEDLE BEARINGS, RACES AND SPACERS.					003 MNR 4 004 PAC 012	
		025		PRESS THRUST BEARING INTO LOWER FLANGE INSTALL TO INSURE PROPER					001 MNR 0P 002 01	
		*REQD*		AND 1 EA ALUM SHAFT. PRESS DRIVE BEAR INTO THRUST BRNG. PLACE 1 EA OF WASHERS & SPROCKETS ON SHAFTS					003 MNR 4 004 PAC 012	
		030		PLACE THRUST WASHERS ON TOP OF SPROCKETS. INSTALL UPPER PLATE AND					001 MNR 0P 002 01	
		*REQD*		UPPER THRUST BRNG. INSTALL BEARING RETAINER. RETAINER BOLTS AND TOP PLATE NUTS.					003 PAC 4 004 PAC 002	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 DOCUMENT/SH	
DISPATCH	FUNCTIONAL CODE	A	C		
		B	D		

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## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	

15. DISPATCH STATION	16. PERF RCC/OP	17. NON C/N	18. MECHANIC	19. "P"	20. "Q"
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15. DISPATCH STATION	16. PERF RCC/OP	17. NON C/N	18. MECHANIC	19. "P"	20. "Q"
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15. DISPATCH STATION	16. PERF RCC/OP	17. NON C/N	18. MECHANIC	19. "P"	20. "Q"
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15. DISPATCH STATION	16. PERF RCC/OP	17. NON C/N	18. MECHANIC	19. "P"	20. "Q"
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15. DISPATCH STATION	16. PERF RCC/OP	17. NON C/N	18. MECHANIC	19. "P"	20. "Q"
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15. DISPATCH STATION	16. PERF RCC/OP	17. NON C/N	18. MECHANIC	19. "P"	20. "Q"
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15. DISPATCH STATION	16. PERF RCC/OP	17. NON C/N	18. MECHANIC	19. "P"	20. "Q"
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15. DISPATCH STATION	16. PERF RCC/OP	17. NON C/N	18. MECHANIC	19. "P"	20. "Q"
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21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. 2 DOCUMENT/SH
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21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. 2 DOCUMENT/SH
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21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. 2 DOCUMENT/SH
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## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED			
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.				
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL							
13. SERIAL NUMBER		14. NOUN									
15. DISPATCH STATION		16. PERF RCC/OP NO.		17. WORK TO BE ACCOMPLISHED IN			18. MECHANIC		19. "P"		
		001		COLUMN 16 IS EQUIVALENT TO DELTA STAMP. 4G12408-101A							
		005		DISASSEMBLE			*C/P MOVE		001 MNF 01		
		*REQD*							003 SD08		
				DEGREASE			*C/P MOVE		001 MNF 01 002 02		
		*REQD*							003 DG02		
							*C/P MOVE		001 MNF 01 002 03		
		*REQD*							003 2702		
				E & I 0.8-1.0-1.0-1.0-1.0-1.05 MIN					001 MNF 01 002 04		
		*REQD*		PISTON RING GROOVE 9.760-9.770 9.755 MIN INSERT: I.D. 1.295 MAX			*C/P MOVE		003 L101		
				NICK & BORE REPAIR			*C/P MOVE		001 MNF 01 002 05		
26		025		VAPOR DEGREASE			*C/P MOVE		001 MNF 01 002 03		
26		030		SHOTPEEN REWORKED AREAS .004-.002 A2					003 DG01		
							*C/P MOVE		001 MNF 01 002 01		
									003 SP01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 DOCUMENT/SN							
DISPATCH		FUNCTIONAL CODE		A		C					
				B		D					



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1

## WORK CONTROL DOCUMENT (MEDS)

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCT/SEC/RCC HNPOT		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO. AF IWG 7926447 &	
10. MODEL-DESIGN-SERIES C-4H-MAIN		11. STOCK NUMBER		12. OPTIONAL SUPPLEMENTS 4S-1-182 4S1-94-3					
13. SERIAL NUMBER		14. FLOATING PISTON							
15. DISPATCH STATION	16. PERFORM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
4G1351	0-101A	1620001164430 17575A 17576A 17577A 17578A 17687A							
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 F.P.I. IAW MIL-STD-6866 STRIP ANODIZE IAW MIL-STD-871 SHOT PEEN IAW MIL-S-13165 ANODIZE IAW MIL-A-8625 TYPE II CLASS II ALODINE IAW MIL-C-5541 COST: \$1362.60 ***MATERIAL: ALUMINUM***							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.							
		SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		"WARNING" MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21047N			
		B		D					

426

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2

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. FLUATING PISTON						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.				18. MECHANIC	19. "P"	20. "O"	
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP. 4613510-101A							
34C5	005	DISASSEMBLE *C/P MOVE					001 MNP GP		
	*REQD*						002 01		
34D	006	DEGREASE ONLY *C/P MOVE					003 SD 03		
	*REQD*						001 MNP GW		
							002 02		
							003 DG 02		
							001 MNP NA		
	*REQD*					M	002 05		
34E	020	E & I					003 ZY 05		
	*REQD*	PISTON RING GROOVE OD 9.760/9.770/9.758					001 MNP GW		
		SEAL GROOVE OD 9.697/9.700/9.695					002 04		
		LOWER END OD 10.115/10.120/10.112					003 EI 01		
		SEAL AREA ID 2.743/2.745/2.747							
		SURFACE AREA ID 2.502/2.504/2.506							
		*C/P MOVE							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21047N			
		B		D					

427

21047N

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3 3

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. FLOATING PISTON						
15. DISPATCH STATION	16. PERCENT RCC/OP (NDO)	17. REMOVE NICKS, TO SCRATCHES AND CORROSION *C/P MOVE				18. MECHANIC	19. 001 MNPRC	20. 002 02	
26	040	STRIP ANODIZE COMPLETE *C/P MOVE					003 BE01		
							001 MNPRC		
							002 03		
							003 AN04		
							001 MNPNA		
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* TAKE PRODUCTION COUNT.*				M	002 02	003 ZA02	
26	050	SHOT PEEN REWORKED AREAS INTENSITY OF .005/.010 A2					001 MNPRC		
							002 01		
							003 SF01		
26	100	ANODIZE COMPLETE TYPE II					001 MNPRC		
							002 03		
		*C/P MOVE					003 AS03		
26	105	ALODINE					005 X857907		
							001 MNPRC		
							002 03		
							003 TA01		
34C5	110	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958					001 MNP GP		
							002 01		
							003 ML06		
34C5	120	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNP GP		
							002 01		
							003 ML06		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21047N			
		B		D					

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. NSN C/MN WORK TO BE ACCOMPLISHED	18. MECHANIC	19. 7 8	20. "Q"
4G1258	3-103A	17576A 17577A 17578A			

REPAIR UNIT PRICE: \$509.85

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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

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318





**11 DATE**

PAGE\_\_OF\_\_PAGES

931

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN						
18. DISPATCH STATION	19. PEAR RCC/OP NO.	17. FITTING LUG HOLE (SML) BORE AS NECESSARY TO BE ACCOMPLISHED TO EXCEED 1.150 WALL THICKNESS. MACHINE OUTSIDE FACE OF LUG A MIN. OF .040 CHAMFER BORE .04/.07 X 45 DEGREES *O/P MOVE				18. MECHANIC	19. QN. RB	20. "Q"	
							001 QN. RB		
							002 RBV1		
69	065	FITTING LUG HOLE (LG) BORE AS NECESSARY TO CLEANUP NOT TO EXCEED 1.200 WALL THICKNESS. MACHINE OUTSIDE FACE OF FLANGE .050 MIN. NOT TO EXCEED MIN THICKNESS OF .050 CHAMFER BORE .04/.07 X 45 DEGREES *O/P MOVE					001 QN. RB		
							002 RBV1		
69	070	MACHINE B.D. TO 1.200 MIN. WITH A MIN. WALL OF .120 *O/P MOVE					001 QN. RB		
							002 RBV1		
69	075	PIN HOLES REPAIR IF EXISTING HOLES EXCEED .003 INCHES. PATCHES TO 0.275 MIN & 0.400 MAX. *O/P MOVE					001 QN. RB		
							002 RBV1		
25	080	SHOTPEEN LOCAL REWORK AREA IDENTITY OF .0004/.0005 H.D. LUGS *O/P MOVE					001 QN. RB		
							002 RBV1		
25	085	SHOTPEEN FINISH I.D. OF LUG HOLES HAND POLISH I.D. OF LUG HOLES *O/P MOVE					001 QN. RB		
							002 RBV1		
8	090	HOLE I.D. AFTER SHOTPEEN NOT TO EXCEED 1.535 AS RMS *O/P MOVE					001 QN. RB		
							002 RBV1		
8	093	HAND POLISH I.D. AFTER SHOTPEEN NOT TO EXCEED 1.545 AS RMS					001 QN. RB		
							002 RBV1		
							003 RBV1		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 pages/8N	
DISPATCH	FUNCTIONAL CODE	A	C		
		B	D		

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# WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6 DATE COMPLETED
7 PART NUMBER		8 TECH DATA		9 ITEM SERIAL NO.

10 MODEL DESIGN SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN	

15 DISPATCH STATION	16 PERM RCC/OP NO.	17 ANDRIZE HOUSING O.D. TYPE II CLASS II WORK TO BE ACCOMPLISHED	18 MECHANIC	1901 MNR RC 0001 02	1902 "Q"
26	100	ANDRIZE HOUSING I.D. TYPE II CLASS II		001 MNR RC 002 02	
26	105	HAND ANDRIZE I.D. COMPLETE TYPE FIT CLASS I		001 MNR RC 002 02	
26	110	ADJUSTING MINOR REWORK REPAIR AD/P MOVE		001 MNR RC 002 02	
		[REDACTED] WIND ALUM WIRE BR		001 MNR RC 002 02	
69	120	MACHINE FLAME SPRAY TO 1.998/1.996 REWORK REPAIR DIMENSIONS IF REMOVED LIMITS ARE EXCEEDED REWORK REPAIR & CAUSE FOR EXCEEDING REWORK REPAIR		001 MNR RC 002 02	
69	124	MACHINE SMALL BUSHING P/N 66032000-52A01		001 MNR RC 002 02	
69	125	INSTALL (SMALL) BUSHING P/N 66032000-52A01		001 MNR RC 002 02	
69	127	USE .0005/.0015 PRESS FIT. REAM TO 0.6248/0.6252 AD/P MOVE MACHINE LARGE BUSHING P/N 66032000-52A01		001 MNR RC 002 02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

U.S. GOVERNMENT PRINTING OFFICE: 1980-648-103

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN
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15. DISPATCH STATION	16. PERP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. MNR	20. "Q"
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3405	135	INSTALL (LARGE) BUSHING P/N 440390 USE .0005/.0015 PRESS FIT. REAM TO 0.9376/0.9390 *C/P MOVE PRESSURE TEST & MARK LEAKING PLUGS *C/P MOVE		001 MNR 002 01	001
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69	140	REMOVE DEFECTIVE LEE PLUGS AS MARKED & RE-INSTALL WITH A NEW LEE PLUG P/N 468101 P/N 478101		001 MNR 002 01	001
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69	145	FITTING LUG (SMALL) BUSHING INSTALLATION USE BUSHING PRESS FIT .0005/.0015 MS21241-08A012 P/N MS21241-08A012		001 MNR 002 01	001
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69	150	INSTALL HELICOILS *C/P MOVE		001 MNR 002 01	001
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69	155	FITTING LUG (LARGE) BUSHING INSTALLATION USE BUSHING PRESS FIT .0005/.0015 MS21241-12A012 P/N MS21241-12A012		001 MNR 002 01	001
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69	158	MACHINE PIN BUSHINGS (A) FROM 4130 STEEL		001 MNR 002 02	001
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21. FINAL DESTINATION	22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/EN
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DISPATCH	FUNCTIONAL CODE	A	C
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		B	D
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# WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN
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15. DISPATCH STATION	16. PERP RCC/OP NO.	17. INSTALL 4 EA PIN RUSH MADE FROM WORK TO BE ACCOMPLISHED	18. MECHANIC	19. MIN RA	20. "Q"
		BRUSH CAD PLATE 0.0004/0.0007 PRESS FIT REAM TO .3137/.315 RECD 3 WEAR TUBES (COMP. IN JURY)		001 MIN RA	"Q"
		LIMITS ARE EXCEEDED		002 BE01	
		RECORD REASON & CAUSE FOR EXCEEDING RECD RE LEADS			
		NO/P MOVE			
	165	PRESSURE TEST NO/P MOVE		001 MIN RA 002 01	
				003 BE01	
	170	PAINT NO/P MOVE		001 MIN RA 002 01	
				003 BE01	
	175	FINAL ACCEPTANCE OF WORK CONTROL RECD FOR COMPLETION & CLOSURE		001 MIN RA 002 01	
		IF ALL PRECEDING OPERATIONS THIS 718		003 BE01	
	180	FINAL PRODUCT VISUAL INSPECTION NO/P MOVE		001 MIN RA 002 01	
				003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

# WORK CONTROL DOCUMENT (MEDS)

1. DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL DESIGN-SERIES				11. STOCK NUMBER		12. OPTIONAL			
13. SERIAL NUMBER				14. NOUN		DRAWING 4613571 45-1-182 451-93-0 & SUPPLEMENTS <b>17575A</b>			
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. NSN C/N WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		17576A 17577A 17578A							
		GOVERNMENT DIRECTIVES: AFLOX 44-81 MAINT 44-11							
		I/O PLATE IAW MIL-C-80488A FMR IAW MIL-S1D-17497 P/O NO1561 BAKE IAW AG-1-102							
		TEMPER ETCH IAW MIL-S7D-267 ALDINE IAW MIL-C-8541 P/O PLATE IAW MIL-S7D-850							
		TP 11 CL 11 BLAST IAW MIL-STB-1504 AMMIL STEEL 180,000 - 220,000 FOS COST 1.44 70							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PROCEDURES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND ITS SUPPLEMENTS REFERENCED IN BLOCK 12 OF THIS WORK FORM AND THE APPROPRIATE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		"WARNING" (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. 2 DOCUMENT/EN			
DISPATCH	FUNCTIONAL CODE	A		C					
		B		D					

# WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2 JOB ORDER NO.	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED.	6 DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. MANY OF THE FOLLOWING REPAIR PROCEDURES WORK TO BE ACCOMPLISHED ON EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.  *REQD* (MANDATORY REQUIREMENT) IN COLUMN 18 IS FOLLOWED BY (1) OF 1A SIGNIF.	18. MECHANIC	19. "P"	20. "Q"
	001	4812571-101A			
2415	005	DISPOSABLE *C/P MOVE		001 MHPSP	
	*REQD*			002 MS03	
2411	006	DEGREASE ONLY *C/P MOVE		001 MHPSP	
	*REQD*			002 MS03	
2412	007	PLAST CLEAN ONLY *C/P MOVE		001 MHPSP	
	*REQD*			002 MS03	
2413	011	WASH WITH 47-250-2100		001 MHPSP	
	*REQD*			002 MS03	
	*REQD*	DATE IN, TIME IN DATE OUT, TIME OUT *C/P MOVE		001 MHPSP	
2414	013	FMPI *C/P MOVE		001 MHPNA	
				002 MS03	
				003 MS03	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	



## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. E & I WORK TO BE ACCOMPLISHED	18. MECHANIC	19.01 MNR	20.01
	*REQD*	VISUAL INSPECTION AND MINOR REMOVAL OF NICKS, BURRS, SCRATCHES, & CORROSION. *C/P MOVE		002 04	"Q"
26	040	TEMPER ETCH REWORKED AREAS		001 MNR NA	001 04
		DATE OUT _____ TIME OUT _____ *C/P MOVE ***** N U T E ***** IF LAST NUT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT ***** BASE AHS AT 300-400 NUTS PER HOUR		003 1003	
26B	050	DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		001 MNR NA	001 04
		***** N U T E ***** IF LAST NUT OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****		003 1001	
26	062	VAPOR DEGREASE *C/P MOVE		001 MNR NA	001 04
26	064	STRIP CAD *C/P MOVE		001 MNR NA	001 04
				003 CS01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

# WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	

15. DISPATCH STATION	16. PERP RCC/OP NO.	17. STRIP RUST WORK TO BE ACCOMPLISHED	18. MECHANIC	19. 001 MNR RC 002 "Q"
		*C/P MOVE		
26	068	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD-TIT PLATED SCAP MEAS		003 CS02 001 MNR RC 002 01
26	070	CAD PLATE TYPE 2 CLASS 3 DATE OUT _____ TIME OUT _____ *C/P MOVE		003 BL02 001 MNR RC 002 03
26B	080	BAKE 23 HRS WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE		003 CA01 001 MNR RC 002 02
				003 BK01
26	090	IRIDITE (CHROMATE CONVERSION COATING) *C/P MOVE		003 IR01 001 MNR RC 002 02
8A	100	FILE FILE *C/P MOVE ***** IF LAST NDI OPERATION IS COMPLETION HERE, TAKE PRODUCTION COOK *****		003 TA01 001 MNR RC 002 04
26	102	IVD PLATE (INITIATED BY PLATING) *C/P MOVE		003 IV01 001 MNR RC 002 03
26	104	ALODINE IVD PLATED AREAS (INITIATED BY PLATING) *C/P MOVE		003 TA01 001 MNR RC 002 03

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

## DATE \_\_\_\_\_

PAGE 07 OF PAGE

440

\* U.S. GOVERNMENT PRINTING OFFICE: 1989-549-123

## DOCUMENT (MEDS)

1 DATE 89040

PAGE 1 OF 1 PAGES

4 PRODUCTION SEC/RCC

5. DATE SCHED

6. DATE COMPLETED

MNPBP

8. TECH DATA

45-1-182

451-93-3

9. ITEM SERIAL NO.

10. DESIGN-SERIES

11. STOCK NUMBER

12. OPTIONAL

E-5A MLG

17575A

13. SERIAL NUMBER

14. NOUN

BALLSCREW PIN

15. DISPATCH STATION

16. PERP. RCC/OP NO.

17.

WORK TO BE ACCOMPLISHED

18. MECHANIC

19.

20.

P/N

4G13605-103A

NSN

C/N

5315001451779

17575A

~~17575A~~

17577A

17575A

GOVERNING DIRECTIVES: AFLOR 66-51

MANO1 66-0

BAKE

IAW

45-1-182

MANO1 74-12

BLAST

IAW

MIL-STD-1504

FPI

IAW

MIL-STD-6866

STRIP

IAW

MIL-STD-371

GEL

IAW

MIL-STD-886

SHOT PEEN

IAW

MIL-S-13165

CHROME PLATE

IAW

MIL-STD-1501

TP II CL III

COST: \$107.16

\*\*MATERIAL: STAINLESS 200,000 PSI\*\*

ALL PERSONNEL INVOLVED IN THE WORK  
PROCESS SPECIFIED IN THIS DOCUMENTHAVE BEEN THOROUGHLY TRAINED AND ARE  
FAMILIAR WITH ALL PERSONNEL SAFETY,  
PRACTICES AND HAZARDS CONTAINED IN  
THE BASIC TECHNICAL MANUAL AND THESUPPLEMENTS REFERENCED IN BLOCK 8  
OF THIS AFLO FORM 958. THE APPLIC-  
ABLE I.O.'S AND SUPPLEMENTS WILL  
ALWAYS BE USED IN CONJUNCTION WITH  
THIS DOCUMENT.\*COMPONENTS WILL BE THOROUGHLY  
CLEANED AND PROTECTED (C/P MOVE) FOR  
MOVES BETWEEN OPERATIONS/DISPATCH  
STATIONS.

"WARNING"

(CONTINUED)

21. FINAL DESTINATION

22. COORDINATION/INITIATING RCC SIGNATURE/DATE

23. DOCUMENT/EN

DISPATCH

FUNCTIONAL CODE

A

C

21051N

B

D

44

## 21051N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN BALLBCKW PIN						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDING PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 15 IS EQUIVALENT TO DELTA START.							
	001	AB10505-100A							
	005	DISPATCH ONLY					001 BMR DM		
	*REQD*						002 01		
							003 5003		
		DECREASE ONLY					001 MNR DM		
	*REQD*						002 02		
							003 5002		
		LIFE, CLEAN ONLY					001 MNR DM		
	*REQD*						002 03		
							003 5001		
		MAKE WIRE AT 500-ALOP					001 MNR DM		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
							003 BK03		
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
		*C/P MOVE				M	001 MNR NA		
	*REQD*						002 05		
							003 ZY05		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21051N			
		B		D		442			

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL/DESIGN/SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN BALL BEARING PIN						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		E & I					001 MNHBM		
	*RECD*	PIN O.D. 1.5950/1.5985 *C/P MOVE					002 04		
							003 ET01		
69	040	RECENTER ENDS FOR GRIND IF REQUIRED *C/P MOVE					001 MNRB		
							002 02		
							003 LE76		
8	050	FIRST GRIND PIN O.D. TO CLEAN-UP MINIMUM 1.5035 *C/P MOVE					001 MNRB		
							002 01		
							003 BE00		
21	070	VAPOR DEBRIDE *C/P MOVE					001 MNRB		
							002 02		
							003 001		
22	100	SHARPEN 220-400 G.R. 0.0007/0.012 G *C/P MOVE					001 MNRB		
							002 01		
							003 9901		
23	008	PREPARE O.D. OF CHROME PLATE. MARK/FIXTURE ETC. MECHANIC SIGN OFF REQUIRED-----					001 MNRB		
							002 02		
							003 001		
24	012	PREPARE O.D. OF CHROME PLATE. GRIND BALL *C/P MOVE					001 MNRB		
							002 01		
							003 001		
25	210	CHROME PLATE 1.5035 MINIMUM GRIND BALL *C/P MOVE DATE OUT TIME OUT					001 MNRB		
							002 02		
							003 001		
		MECHANIC SIGN OFF REQUIRED----- *C/P MOVE					003 0010		
26	100	BARE CHROME AT 350-400 G WITHIN 4HR. OF CHROME DATE IN TIME IN (CONTINUED)					001 MNRB		
							002 02		
							003 BK01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21051N			
		B		D					

443



21052N

89040

1

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCT/REC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER		8. TECH DATA 4S-1-182 4S1-93-3 & SUPPLEMENTS				9. ITEM SERIAL NO.			
10. MODEL DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL					
13. SERIAL NUMBER		14. MOUNTON CARRIER							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
4G1351	4-101A	1620001164431 17575A 17576A 17577A 17578A 17687A							
		GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3							
		F.P.I. IAW MIL-STD-6866 STRIP ANODIZE IAW MIL-STD-871							
		ANODIZE IAW MIL-A-8625 ALODINE IAW MIL-C-5541 COST: \$297.25 *****MAT'L 7075-T73 ALUMINUM*****							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		*****"W A R N I N G"***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21052N			
		B		D					

445



21052N

89040

2

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE\_\_OF\_\_PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. PISTON CARRIER						
15. DISPATCH STATION	16. PERFORM RCC/OP NO.	17. PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.				18. MECHANIC	19. "P"	20. "Q"	
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	4G13514-101A							
34C5	005	DISASSEMBLE *C/P MOVE					001 MNP GP		
	*REQD*						002 01		
							003 SD03		
34D	006	DEGREASE ONLY *C/P MOVE					001 MNP GW		
	*REQD*						002 02		
							003 DG02		
		*C/P MOVE					001 MNP NA		
	*REQD*					M	002 03		
34E	020	E & I I.D. SEAL GROOVE 1.995-1.997					003 ZY05		
		SERVICE LIMIT 2.000					002 04		
	*REQD*	O.D. 2.498-2.500 SERVICE LIMIT 2.496					003 EI01		
34E	030	NICK & BURR REPAIR *C/P MOVE					001 MNP GW		
							002 04		
							003 EI01		
26	040	STRIP ANODIZE *C/P MOVE					001 MNP RC		
							002 03		
							003 AN04		
		*C/P MOVE					001 MNP NA		
		***** NOTE *****				M	002 02		
		IF LAST NDI OPERATION IS COMPLETED* (CONTINUED)					003 ZA02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21052N			
		B		D					

## WORK CONTROL DOCUMENT (MEDS)

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. PISTON CARRIER						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. HERE, TAKE WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*****							
26	060	ANODIZE TYPE II COMPLETE *C/P MOVE					001 MNPRC		
							002 03		
							003 AS03		
26	070	ALODINE *C/P MOVE					001 MNPRC		
							002 03		
							003 TA01		
34C5	080	FINAL ACCEPTANCE OF WORK CONTROL					001 MNPGP		
	*REQD	DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					002 01		
							003 ML06		
34C5	090	FINAL PRODUCT VISUAL INSPECTION					001 MNPGP		
	*REQD*	*C/P MOVE					002 01		
							003 ML06		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21052N			
		B		D					

492

21053N

89069

1

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA T.O. 4S1-93-3 4S-1-182 AND SUPPLEMENTS				9. ITEM SERIAL NO.	
10. MODEL DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL					
13. SERIAL NUMBER		14. NUMBERING TUBE BASE							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORKS TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
461351	9-101A	1620001233790 17575A 17576A 17577A 17578A 17687A  GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FPI IAW MIL-STD-6866 IVD PLATE IAW MIL-C-83488A FMPI IAW MIL-STD-1949  SHOTPEEN IAW P70 N01561 CAD-PLATE IAW MIL-S-13165 MIL-STD-870 TP II CL II  BAKE IAW 4S-1-182 MAOI 74-12 TEMPER ETCH IAW MIL-STD-867 ALODINE IAW MIL-C-5541  BLAST IAW MIL-STD-1504 CHROME PLATE IAW MIL-STD-1501 GRIND IAW MIL-STD-866  * * * * * S T E E L * * * * *  MAT'L: 4330 200,000-220,000 KSI COST: \$711.37  ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21053N			
		B		D					

448

21053N

89069

2

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. MOUNTING TUBE BASE						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		*****W A R N I N G***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	4613519-101A							
34C5	005	DISASSEMBLE *C/P MOVE					001 MNP GP		
	*REQD*						002 01		
							003 SD03		
34C	007	CHEM CLEAN *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 SL01		
34B	009	BLAST CLEAN ONLY *C/P MOVE					001 MNP GW		
	*REQD*						002 03		
							003 BL07		
34B	011	BAKE 4 HRS AT 350-400F					001 MNP GW		
	*REQD*	DATE IN _____ TIME IN _____					002 03		
							003 BK03		

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21053N
		B	D	

442

21053N

1 DATE

89067

3

## WORK CONTROL DOCUMENT (MEDS)

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. METERING TUBE BASE						
18. DISPATCH STATION	19. PERP RCC/OP NO.	17. DATE OUT WORK TO BE ACCOMPLISHED				*C/P MOVE	18. MECHANIC	19. "P"	20. "Q"
34M	018	F.M.P.I. J				*C/P MOVE		001 MNPNA	
	*REQD*						M	002 05	
34E	020	E & I						003 MS03	
	*REQD*	I.D. 1.251-1.253 SERVICE 1.255						001 MNPBW	
		I.D. SEAL GROOVE 1.491-1.493						002 04	
		SERVICE 1.495						003 E101	
		O.D. 4.490-4.492 SERVICE 4.488							
		O.D. SEAL GROOVE 4.120-4.122							
		SERVICE 4.118							
34E	030	NICK & BURR				*C/P MOVE		001 MNPBW	
						*C/P MOVE		002 04	
								003 E101	
26	040	VAPOR DEGREASE				*C/P MOVE		001 MNPRC	
								002 03	
								003 DG02	
26	050	STRIP CAD				*C/P MOVE		001 MNPRC	
								002 02	
								003 CS01	
26	060	STRIP RUST				*C/P MOVE		001 MNPRC	
								002 03	
								003 CS02	
8	070	1ST GRIND SEAL GROOVE O.D. AS						001 MNPRB	
		REQUIRED TO CLEAN UP NOT TO EXCEED						002 03	
		A MINIMUM DIMENSION OF 4.108.						003 GE02	
26	080	TEMPER ETCH				*C/P MOVE		001 MNPNA	
		***** NOTE *****					M	002 06	
		IF LAST NDI OPERATION IS COMPLETED						003 TE03	
		(CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21053N			
		B		D					

450

21053N

89069

4

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NEUTERING TUBE BASE						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. HERE, TAKE PRODUCTION COUNT WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "G"	
		*****							
26B	090	BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF ETCH. DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE F.M.P.I. : _____ *C/P MOVE					001 MNPRC		
							002 02		
8A	100						003 BK01		
		***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****				M	001 MNPNA		
							002 02		
							003 ML04		
26	110	VAPOR DEGREASE *C/P MOVE					001 MNPRC		
							002 02		
							003 DE02		
26	120	SHOTPEEN LOCALLY REWORKED AREA 0.008-0.013A2 *C/P MOVE					001 MNPRC		
							002 01		
							003 SF02		
26	130	SHOTPEEN SEAL GROOVE O.D. 0.008- 0.013A2 *C/P MOVE					001 MNPRC		
							002 01		
							003 SF02		
26	140	PREPARE O.D. SEAL GROOVE FOR CHROME PLATE, MASK/FIXTURE/ETC. MECHANIC SIGNOFF REQUIRED-----> *C/P MOVE					001 MNPRC		
							002 01		
							003 BE01		
26	150	PREPARE O.D. SEAL GROOVE FOR CHROME PLATE, GRIT BLAST. *C/P MOVE					001 MNPRC		
							002 01		
							003 BL04		
26	160	CHROME PLATE SEAL GROOVE SUFFICIENT TO GRIND BACK TO 4.122. MECHANIC SIGNOFF REQUIRED-----> (CONTINUED)					001 MNPRC		
							002 01		
							003 BL02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21053N			
		B		D					

451

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. METERING TUBE BASE						
18. DISPATCH STATION	16. PERF RCC/OP NO.	17. TIME OUT WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		DATE OUT *C/P MOVE							
26B	170	BAKE 4 HOURS AT 350-400 DEG F WITHIN 4 HOURS OF CHROME. TIME IN _____ DATE IN _____ TIME OUT _____ DATE OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK02		
8	180	FINISH GRIND SEAL GROOVE TO 4.122- 4.120 16 RMS. *C/P MOVE					001 MNPRB 002 02 003 GB02		
26B	190	BAKE 4 HOURS AT 350-400 DEG F DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK02		
26	200	CAD PLATE ALL AREAS NOT CHROME PLATED. *C/P MOVE					001 MNPRC 002 02 003 CA01		
26B	210	BAKE 23 HRS AT 350-400F WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNPRC 002 02 003 BK01		
26	220	IRIDITE *C/P MOVE					001 MNPRC 002 02 003 IR01		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21053N			
		B		D					

21053N

89069

6

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. METERING TUBE BASE						
15. DISPATCH STATION	16. PERP RCC/OP	17. F.M.P.I. WORK TO BE ACCOMPLISHED *C/P MOVE				18. MECHANIC	19.	20.	
	260	***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****				M	001. MNPNA		
							002 04		
							003 ML04		
26	240	VAPOR DEGREASE *C/P MOVE					001 MNPRC		
							002 02		
							003 DE02		
26A	250	F.P.I. /					001 MNPNA		
		*****NOTE***** IF LAST NDI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****				M	002 03		
							003 IV01		
		*C/P MOVE							
26	260	IVD PLATE (INITIATED BY PLATING)					001 MNPRC		
		NOTE: IF CHROME REWORK WAS DONE, OPERATION 210 MUST BE ACCOMPLISHED PRIOR TO IVD OPTION.					002 03		
		*C/P MOVE					003 IV01		
26	270	ALODINE IVD PLATED AREAS (INITIATED BY PLATING)					001 MNPRC		
		*C/P MOVE					002 03		
							003 TA01		
34P	280	PAINT *C/P MOVE					001 MNP GP		
		1. CLEAN 4. 1ST COAT PAINT					002 09		
		2. MASK 5. 2ND COAT PAINT					003 WE03		
		3. PRIME							
34C5	290	FINAL ACCEPTANCE OF WORK CONTROL					001 MNP GP		
		DOCUMENT FOR COMPLETENESS & ACCURACY					002 01		
	*REQD*	OF ALL PRECEDING OPERATIONS THIS 958					003 ML06		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21053N			
		B		D					

453



21053N

89069

7 7

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. METERING TUBE BASE						
15. DISPATCH STATION	16. PERF RCC/OP 300	17. FINAL PRODUCT INSPECTION WORK TO BE ACCOMPLISHED				18. MECHANIC	19.	20.	
	*REQD	*C/P MOVE					001 MN	PGR	
							002 01		
							003 ML	06	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21053N			
		B		D					

454

## 21055N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MAYCOM	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 451-93-3745-1-100 AND SUPPLEMENTS	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES L-54 MAIN LAND K-1000	11. STOCK NUMBER	12. OPTIONAL <b>17575A</b>
13. SERIAL NUMBER	14. NOUN SPINED SL RING	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
PZN 4613473-103A		NSN 1620001238702 CZN 17575A <b>17576A</b> 17577A 17578A			<b>6</b> <b>7</b> <b>8</b>
		GOVERNING DIRECTIVES: AFM 64-51 MADOL 64-5			
		FPI IAW MIL-STD-1500			
		BLAST IAW MIL-STD-1500			
		COST: \$1858.94 AWL 14 0000000000000000			
		ALL PERSONNEL INVOLVED IN THE WORK PERFORMED SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL APPLICABLE SAFETY PRACTICES AND PROCEDURES CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SPECIALIZED REQUIREMENTS THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. PERSONNEL WILL BE THOROUGHLY CLEANLY AND PROPERLY DRESSED FOR MOVES BECAUSE OF AIRCRAFT DISPATCH STATIONS. ***** R N I N ***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REGD* (MANDATORY REQUIREMENT) IN (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	17575A
		B	D	

455

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN SPL LIND BL LING						
18. DISPATCH STATION	19. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP							
	001	401 24 74 11 54							
	005	DISASSEMBLE					001 MNR GP		
	*REQD*						002 01		
							003 SD03		
		DISASSEMBLE ONLY					001 MNR GP		
	*REQD*						002 02		
							003 1002		
		WET BLANK TO CLEAN IF REQUIRED					001 MNR GP		
	*REQD*						002 02		
							003 BR05		
							001 MNR GP		
	*REQD*						002 05		
							003 24-5		
		S & I CONTROL UNIT 251010.005					001 MNR GP		
	*REQD*	SERVICE LIMIT 10 000					002 04		
		SPL LIND BL LING					003 0101		
		SPL LIND BL LING							
		FINE							
	040	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNR GP		
	*REQD*						002 01		
							003 MU06		
	050	FINAL PRODUCT VISUAL INSPECTION					001 MNR GP		
	*REQD*	*C/P MOVE					002 01		
							003 MU06		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21055N			
		B		D					

## 21059N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNPDP	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA 4S1-93-3/4S-1-182		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES C-5A M.L.G.	11. STOCK NUMBER	12. OPTIONAL <b>17575A 72877A</b> <b>6 17687A</b>
13. SERIAL NUMBER	14. NOUN BUAGE	

18. DISPATCH STATION	19. PERP RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	16. MECHANIC	18. "P"	20. "Q"
P/N 63714 4694407	101A	NSN 6685002283784 6685002283784 17577A 17578A 172877A 17687A	<b>7</b> <b>8</b>		
		GOVERNING DIRECTIVES: AFMOR 66-51 HARDI 66-3 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND PROCEDURES CONTAINED IN THE BASIC TECHNIQUE, ORIGIN AND I.D. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (O/P MOVES) FOR MOVES BETWEEN OPERATIONS/DEPARTMENTS.			
		APPROPRIATE SAFETY PRECAUTIONS WILL BE PART OF THE FOLLOWING WORK PROCESSES: PRECAUTIONS WILL BE EMPLOYED TO PRECLUDE INJURIES.			
		*REDO* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	63714 4694407-101A			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21059N
		B	D	

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
-------------------------	------------------	--------------

13. SERIAL NUMBER	14. NOUN BLADE
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18. DISPATCH STATION	19. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
69	000 *RECD*	DISASSEMBLE/REMOVE PROTECTIVE SPRING LOADED COVER & SCREW RETAIN FOR REASSEMBLY *C/P MOVE		001 MM-UP 002 01 003 BL-1	
69	002 42E90*	HAND WASH *C/P MOVE		001 MM-UP 002 01 003 BL-1	
69	020	PLACE GAUGE IN LATHE & ROLL CRIMP BACK TO REMOVE PLASTIC LENS *C/P MOVE		001 MM-UP 002 01 003 BL-2	
69	030	SCRAPE OFF THE 3 GREEN OPERATIONAL MARKS, APPLY 2 COATES OF WHITE ENAMEL PAINT OVER THE PAINTED COE MARKS *C/P MOVE		001 MM-UP 002 01 003 BL-1	
69	040	ATTACH LENS & GO TO STATION 69 *C/P MOVE		001 MM-UP 002 01 003 BL-1	
69	050	INSTALL TUBE & LENS-USE SEALANT MIL-S-8802 AROUND EDGES OF LENS & CRIMP TO RETAIN LENS *C/P MOVE		001 MM-UP 002 01 003 BL-1	
69	060	INSTALL COVER & SPRING *C/P MOVE		001 MM-UP 002 01 003 BL-1	
69	070 *RECD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MM-UP 002 01 003 BL-1	
69	080 *RECD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MM-UP 002 01 003 BL-1	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	21059N
		B	D	

21059N

89040

1

## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE 07 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCT/REC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA 491-93-3/49-1-182				9. ITEM SERIAL NO.		
10. MODEL DESIGN/SERIES		11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER		14. CHANGE							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
G3714	4694407-101A	6685002283784 17575A 6685002283784 17576A 17577A 17578A 72877A 17687A							
		GOVERNING DIRECTIVES: AFLCR 66-51							
		MANOI 66-3							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE							
		FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLIC-							
		ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY							
		CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		*****"W A R N I N G"*****							
		MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO							
		PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN							
		BLOCK 16 SERVES THE SAME PURPOSE AS							
		DELTA STAMP							
	001	G3714							
		4694407-101A							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SH	
DISPATCH	FUNCTIONAL CODE	A	C	21059N	
		B	D		

# WORK CONTROL DOCUMENT (MEDS)

1 DATE 07/07/70

PAGE 01 OF 01 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. SURGE						
18. DISPATCH STATION	16. PERM. RCC/OP (MED)	17. DISASSEMBLY/REMOVE PROTECTIVE SPRING LOADED COVER & SCREW/ RETAIN FOR REASSEMBLY *C/P MOVE				18. MECHANIC	19. 001. MNPGR.01	20. 002 01	
34C5	*REQD* 008	HAND WASH *C/P MOVE					003 BE01		
69	*REQD* 020	PLACE GUAGE IN LATHE & ROLL CRIMP BACK TO REMOVE PLASTIC LENS- *C/P MOVE					001 MNPRA	002 01	
34P	030	SCRATCH OF THE 2 GREEN OPERATING MARKS, APPLY 2 COATES OF WHITE ENAMEL PAINT OVER THE MAIN & NOSE MARKINGS *C/P MOVE					003 BE01	002 02	
34C5	040	ATTACH LENS & TUBE TO GUAGE & RETURN TO STATION 69 *C/P MOVE					001 MNPGR	002 01	
69	050	INSTALL TUBE & LENS-USE SEALANT MIL-S-8802 AROUND EDGE OF LENS & CRIMP TO RETAIN LENS *C/P MOVE					003 BE01	002 02	
34C5	060	INSTALL COVER & SPRING ASSY *C/P MOVE					001 MNPGR	003 BE01	
34C5	070	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNPGR	002 01	
34C5	*REQD* 080	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					003 ML06	002 01	
	*REQD*						003 ML06		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	21057N	
		B	D		

## 21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED		
7. PART NUMBER				8. TECH DATA 451-93-3 & SUPPLEMENTS				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES C5A MLG			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN STRUT ASSY							
15. DISPATCH STATION		16. PERF RCC/OP NO.		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"	
P/N				NSN C/N						
4G11020-107A				1620010054191 17575A						
4G11020-105A				1620010054192 17576A						
4G11020-101A				1620010054193 17577A						
4G11020-103A				1620010054194 17578A						
				GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3						
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT						
				HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY						
				PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O.						
				SUPPLEMENTS REFERENCED. THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL						
				ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.						
				*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR						
				MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.						
				*****"W A R N I N G"*****						
				MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF						
				EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO						
				PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO						
				PRECLUDE INJURIES.						
				*REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS						
				DELTA STAMP						
		001		4G11020-107A 4G11020-105A 4G11020-101A (CONTINUED)						
21. FINAL DESTINATION			22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH		FUNCTIONAL CODE		A		C		21058N		
				B		D				

46P



## 21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		4611020-103A							
34C5	010	***** MATCH - UP ***** NEW/SERVICEABLE REWORKED NO REWORK YOKE ASSY 21015N					001 MNP GP 002 01 003 MU06		
		BALLSCREW ASSY (2) 21069N BALLSCREW SPROCKET 21037N							
		KNEELING DRIVE GEAR ASSY 21045N UPPER SIDE BRACE ARM 21009N							
		UPPER SIDE BRACE SHAFT 21005N LOWER SIDE BRACE ARM 21013N							
		LOWER SIDE BRACE SHAFT 21006N SIDE BRACE APEX BOLT 21025N							
		RETRACT ARM ASSY 21018N TRUNNION PIN 21019N							
		TRUNNION CROSS BOLT (2) 21024N OUTER CYL ASSY 21001N							
		ANCHOR SHAFT (2) 21034N BALLSCREW CROSS PIN (2) 21051N							
		POSITIONING COLLAR 21016N ANTI ROTATION BOLT (2) (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21058N			
		B		D					

## 21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY						
18. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		21020N CROSSWIND APEX BOLT 21017N PISTON SUB ASSY							
		21088N SPLINED ORIFICE TUBE 21007N RESTRICTOR							
		21046N SPLINED SLIDE RING 21055N PACKING NUT							
		21062N LOWER BEARING 21040N UPPER BEARING							
		LOCK RING ASSY 21030N COLLAR LOCK INSERT 21035N							
		COLLAR LOCK COLLAR 21026N THRUST BEARING 21041N							
		ROTATION COLLAR 21036N SPLINED TUB NUT 21060N							
		ROLL PIN 21041N ROLL PIN ROUND NUT 21038N							
		HEADLESS APEX PIN 21011N FLUID TRANSFER HOUSING 21048N							
		STEPPED SWIVEL FTG 21091N (INT) SWIVEL FTG (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21058N			
		B		D					

A63

## 21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 4 OF 4 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		21093N <i>MT</i> LARGE SWIVEL FTG 21093N GAUGE (2)							
		21059N STRUT HEADER SHEET 000097							
34C5	<del>015</del> *REQD*	PLACE YOKE UPSIDE DOWN IN YOKE FIXTURE AND INSTALL "O" RING AND THRUST WASHER					001 MNP GP 002 01 005 CC22		
34C5	<del>020</del> *REQD*	ASSEMBLE BALLSCREWS, SPROCKETS, THRUST BEARINGS, RADIAL BEARINGS AND RETAINERS INTO THE BALLSCREW BORE					001 MNP GP 002 01 003 CC22		
34C5	<del>025</del> *REQD*	PLACE YOKE ASSY IN PREASSY STAND AND INSTALL OUTER CYL AND ELECT INSERT ACCORDING TO PROPER CONFIGURATION					001 MNP GP 002 01 003 PA04		
34C5	<del>030</del> *REQD*	PLACE POSITIONING COLLAR ON OUTER CYL AND INSTALL SHAFTS, BRACKETS, ELECT HARNESS ASSY MANIFOLDS AND HYD TUBING IN SEQUENCE					001 MNP GP 002 01 003 PA04		
34C5	<del>035</del> *REQD*	INSTALL HYD FLEX LINES, CROSSWIND SYSTEM, VALVES AND LOCK CYLS, INSTALL KNEELING SYSTEM AND CHAIN COVER.					001 MNP GP 002 01 003 PA04		
34C5	<del>040</del> *REQD*	INSTALL ROTATION CYL. CONNECT ALL ELECT LEADS AND COMPLETE ELECT HARNESS ASSY.					001 MNP GP 002 01 003 PA04		
34C5	<del>045</del> *REQD*	TORQUE ALL HYD LINES, FITTINGS AND TUBING IAW TORQUE VALVE TABLE ON PAGE 9-4 IN T.O. 451-93-3					001 MNP GP 002 01 003 PA04		
34C5	<del>050</del> *REQD*	MOVE STRUT INTO TEST STAND AND SECURE IT. CLEAN I.D. OF OUTER CYL TO REMOVE ANY AND ALL FOREIGN (CONTINUED)					001 MNP GP 002 01 003 FA05		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21058N			
		B		D					

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL					
13. SERIAL NUMBER		14. NOUN STRUT ASSY							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		MATERIAL-- OK TO ASSEMBLE OR CLOSE							
34C5	*REQD*	ASSEMBLE ALL ITEMS REQUIRED TO BUILD UP THE O.D. OF THE PISTON SUB ASSY INSTALL SPLIED TUBE ASSY.					001 MNP GP 002 01 003 FA05		
34C5	*REQD*	INSURE THAT ALL ALIGNING MARKS ON ALL ITEMS ARE PROPERLY ALIGNED. INSURE THAT ALL TABS ARE LOCKED PROPERLY.					001 MNP GP 002 01 003 FA05		
34C5	*REQD*	GREASE I.D. OF OUTER AND UPPER & LOWER BEARINGS AND INSTALL PISTON SUBASSY IN OUTER CYL AND LOCK IN PLACE.					001 MNP GP 002 01 003 PA05		
34C5	*REQD*	INSTALL ALL ITEMS USE TO BUILD UP THE TOP END. FILL UPPER CHAMBER WITH 13+/- GALS OF HYD FLUID STROKE STRUT TO REMOVE TRAPPED AIR.					001 MNP GP 002 01 003 FA05		
34C5	*REQD*	CHARGE STRUT WITH 2500 +/- PSI IN LOWER CHAMBER AND 475 +/- PSI IN UPPER CHAMBER ALL PRESSURE TO STABILIZE APPROX 30 MIN.					001 MNP GP 002 01 003 FA05		
34C5	*REQD*	USING A TOTALIZING VESSEL AT LOWER CHAMBER ALLOWABLE LEAKAGE IS 100 CC IN ONE HR WITH A PRESSURE GAUGE. THERE SHALL BE NO LOSS/GAIN FROM UPPER CHAMBER FOR 1 HR.					001 MNP GP 002 01 003 FA05		
34C5	*REQD*	CYCLE STRUT 25 TIMES AT 300 PSI TO CHARGE ALL HYD LINES AND CYLS PERFORM LOW PRESSURE ROTATION TEST AND RECORD PRESSURES: NORMAL ROTATION 0-90 DEGREES _____ NORMAL ROTATION 90-0 DEGREES _____ (CONTINUED)					001 MNP GP 002 01 003 FA05		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21058N			
		B		D					

## 21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 6 OF 6 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		LOCKED AT _____ EM9 ROTATION 90-0 DEGREES							
		LOCKED AT _____							
34C5	<del>1094</del> *REQD*	CYCLE CROSSWIND CYLS 25 TIMES AT 3000 PSI AND CHECK ALL HYD LINES AND TUBES THERE SHALL BE NO LEAKAGE AT ANY CONNECTION					001 MNP GP	002 01 003 FA05	
34C5	<del>1095</del> *REQD*	CHECK AND SET THE INTER LOCK SYSTEM SET AND CHECK BALLSCREW RIGGING AND SAFETY WIRE DOG STOPS AND HEX NUTS.					001 MNP GP	002 01 003 FA05	
34C5	<del>1096</del> *REQD*	INSTALL FLUID TRANSFER HOUSING, IN FLIGHT BRAKE SYSTEM, ROLL PIN ASSY, SIDE BRACES, RETRACT ARM, AND TRUNNION PIN.					001 MNP GP	002 01 003 FA05	
34C5	<del>1097</del> *REQD*	CLEAN OFF ALL EXCESS GREASE, OIL AND DIRT FROM ENTIRE STRUT. DECAL AND TOUCH UP PAINT A REQUIRED.					001 MNP GP	002 01 003 FA05	
34C5	<del>1114</del> *REQD*	INSPECT STRUT OVER ALL FOR RUBBING AND CHAFING HYD LINES. WRAP AND PROTECT ELECT CANNON PLUGS.					001 MNP GP	002 01 003 FA05	
34C5	<del>1115</del> *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNP GP	002 01 003 FA05	
34C5	<del>1201</del> *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNP GP	002 01 003 FA05	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21058N			
		B		D					

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MNPBP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4S-1-182 4S1-93-3 AND SUPPLEMENTS	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES C-5A MLG	11. STOCK NUMBER	12. OPTIONAL <b>17575A</b>
13. SERIAL NUMBER	14. NOUN ROUND MUF	

15. DISPATCH STATION	16. PERP RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
P/R		NSM C/N			
4013614-101A		5810004582848 17575A <del>17575A</del> 17577A 17578A			<b>6</b> <b>7</b> <b>8</b>
		GOVERNMENT DIRECTIVES: AFLOK 66-51 MANUL 66-3 1MB PLATE IAW MIL-C-83482A 1MB IAW MIL-STD-1249 P/D NO1561 BLAST IAW MIL-STD-1504 1MB PLATE IAW MIL-STD-1504 1MB IAW 4S-1-182 MALL 74-11 ALCLINE IAW MIL-C-8541 WORKMAN-IL STEEL (220-240 KSI) K&K 1050 1509 01			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE LATEST TECHNICAL ORDER (A.O.) IN THE WORKMAN-IL STEEL (220-240 KSI) K&K 1050 1509 01			
		APPROPRIATE P.D.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF (CONTINUED)			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21060N
		B	D	

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN ROUND NUT	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REDD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			
	001	4013614-101A			
	000	DISASSEMBLE			
	*REDD*				001 MNR 1P 002 01 003 SD13
		OPEN CLEAN			
	*REDD*				001 MNR 2W 002 03 003 SL01
		CLOSE CLEAN ONLY			
	*REDD*				001 MNR 2W 002 03 003 0107
		BAKE 4 HRS AT 300-400 DEG F.			
	*REDD*	DATE IN TIME IN			001 MNR 2W 002 03 003 BK03
		DATE OUT TIME OUT			
		*C/P MOVE			
		(ANY CRACKING SHALL BE CAUSE FOR CONDEMNATION.)			
	*REDD*				001 MNR NA 002 05 003 MS03

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21060N
		B	D	

960

U.S. GOVERNMENT PRINTING OFFICE: 1980-446-140

## 21060N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040

3  
PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL					
13. SERIAL NUMBER		14. NOUN ROUND NO1							
18. DISPATCH STATION	19. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		E AND 1: VISUAL INSPECT & HAND POLISH NICKS AND BURRS *REQD* *C/P MOVE					001 MNHRC 002 04 003 EI01		
26	022	VAPOR DEGREASE *C/P MOVE					001 MNHRC 002 08 003 LB01		
26	024	STRIP OAD *C/P MOVE					001 MNHRC 002 02 003 LB01		
26	026	STRIP RUST *C/P MOVE					001 MNHRC 002 02 003 LB02		
26	028	PRIOR TO CAD/170, GRIT BLAST ALL AREAS TO BE CAD/170 PLATED *C/P MOVE					001 MNHRC 002 02 003 EI02		
26	030	CAD PLATE DATE OUT _____ TIME OUT _____ *C/P MOVE					001 MNHRC 002 02 003 CAD		
26	040	PAKE 23 HRS AT 500-40000 WITHIN 4 HRS OF CAD DATE IN _____ TIME IN _____					001 MNHRC 002 02 003 CAD		
		DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	050	IRIDITE *C/P MOVE					001 MNHRC 002 02 003 IR01		
		*C/P MOVE ***** NOTE ***** IF LAST NO1 OPERATION IS COMPLETED* (CONTINUED)				M	001 MNHRC 002 06 003 ML04		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21060N			
		B		D					



2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED			
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL					
13. SERIAL NUMBER			14. NOUN ROUND TUF								
15. DISPATCH STATION		16. PERF RCC/OP NO.		17. WORK TO BE ACCOMPLISHED		18. MECHANIC		19. "P"		20. "Q"	
				HERE, TAKE PRISON 100 DUMB *****							
25		062		IVD PLATE (INITIATED BY PLATING) *O/P MOVE				001 BNR MC 002 CC 003 T001			
26		064		ALDING IVD PLATED AXLES (INITIATED BY PLATING) *O/P MOVE				001 BNR MC 002 CC 003 T001			
		070		REINT AS REQ'D *O/P MOVE				001 BNR MC 002 CC 003 T001			
		072		FINAL RECEIPT OF WORK FOR THE DOCUMENT FOR COMPLETION & REVIEW OF ALL PRECEDING OPERATIONS				001 BNR MC 002 CC 003 T001			
		070		FINAL PRODUCT VISUAL INSPECTION *O/P MOVE				001 BNR MC 002 CC 003 T001			
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN					
DISPATCH		FUNCTIONAL CODE		A		C		21060N			
				B		D					

## 21062N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89040

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC MMPSP	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA 4S-1-182/4S1-93-3 UNG 4G12437-105A	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES 05 MLS	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN PACKING NUT
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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P/RN 4G12437-105A		NSN 4730011819672	D/RN 17578A <del>17578A</del> 17577A 17578A		
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		GOVERNING DIRECTIVE: AFM 66-51 MAMC 66-0 IWD PLATE 14W MIL-C-84800 ALUMINUM 14W MIL-C-8541			
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		FMPI 14W MIL-STD-1549 TEMPER ETCR 14W MIL-STD-1547 SOL PLATE 14W MIL-STD-1549			
--	--	---	--	--	--

		GRD PLATE 14W MIL-STD-1549 BLAST 14W MIL-STD-1549 BAKE 14W 4S-1-182			
--	--	---	--	--	--

		MAT'L: 300H 200,000-300,000 KSI COST: \$408.06 ALL PERSONNEL INVOLVED IN THE WORK			
--	--	---	--	--	--

		PROCEDURES DESCRIBED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL FIRST AID EMERGENCY PROCEDURES AND FIRST AID KIT			
--	--	--	--	--	--

		THE BASIC TECHNICAL ORDER AND ALL SUPPLEMENTS REFERENCED IN THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH			
--	--	--	--	--	--

		THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (D/P MOVE) FOR MOVES BETWEEN OPERATIONS/ DISPATCH			
--	--	--	--	--	--

		STATIONS. *****P W A R N I N G***** MANY OF THE FOLLOWING REPAIR (CONTINUED)			
--	--	---	--	--	--

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21062N
		B	D	

PREVIOUS EDITION WILL BE USED

## 21062N WORK CONTROL DOCUMENT (MEDS)

11 DATE 89040

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN PACKING NUT						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		VISUAL INSPECT ROUTE FOR MODIFICATION IF REQUIRED *REGO* *C/P MOVE					001 MNRSM 002 04 003 E101		
		NICK & BURN REPAIR *C/P MOVE					001 MNRSM 002 04 003 E101		
26	042	VAPOR DEGRASE *C/P MOVE					001 MNRSM 002 04 003 E101		
26	044	STRIP GAD *C/P MOVE					001 MNRSM 002 02 003 E101		
26	045	STRIP RLSY *C/P MOVE					001 MNRSM 002 02 003 E102		
27	050	MACHINE/MODIFY NOT LAW DWS 401340 *C/P MOVE					001 MNRSM 002 02 003 MNRSM 004 15 45475		
							001 MNRSM 002 02 003 E101		
		DATE 01/01/00 TIME 00:00 *C/P MOVE ***** NOTE ***** IF LAST NOI OPERATION IS COMPLETED HERE, TAKE PRODUCTION COUNT *****					001 MNRSM 002 02 003 E101		
258	070	BAKE 4 HRS AT 350/400 DEGREES WITHIN 4 HRS OF ETCH DATE IN _____ TIME IN _____ (CONTINUED)					001 MNRSM 002 02 003 BK01		

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
DISPATCH	FUNCTIONAL CODE	A	C	21062N	
		B	D		

422

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN PACKING REL
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15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		DATE OUT _____ TIME OUT _____ *C/P MOVE			
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		DATE OUT _____ TIME OUT _____ *C/P MOVE			
--	--	--	--	--	--

		DATE OUT _____ TIME OUT _____ *C/P MOVE			
--	--	--	--	--	--

26	080	VARIOUS DISCREPANCY	*C/P MOVE	001 MMHNA	002 06	003 MLOA
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26	090	CHD/CLERK REWORKED AREAS	*C/P MOVE	001 MMHNA	002 01	003 SP 1
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26	090	PHASE TO CAD/CLERK, OMIT CAD/CLERK AREAS TO BE CAD/CLERK PLAYED	*C/P MOVE	001 MMHNA	002 01	003 BL02
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26	100	DATE OUT _____ TIME OUT _____ *C/P MOVE				
----	-----	--	--	--	--	--

26	110	DATE IN _____ TIME IN _____ *C/P MOVE				
----	-----	--	--	--	--	--

		DATE OUT _____ TIME OUT _____ *C/P MOVE				
--	--	--	--	--	--	--

26	120	INCLUDE CHRONODATE CONVERSION (CA - ING)	*C/P MOVE	001 MMHPC	002 02	003 IR01
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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21062N
		B	D	

PREVIOUS EDITION WILL BE USED

## 21069N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 1 OF 1 PAGES

2. JOB ORDER NO. 74652A		3. QUANTITY		4. PRODUCTION SEC/RCC BNRPP		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER 4694034-101A				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES CSA MLG		11. STOCK NUMBER 1400001486466			12. OPTIONAL 16.3-2-80-3 46-1-182 AND SUPPLEMENTS				
13. SERIAL NUMBER		14. NOUN BRILL BURST AWAY			74652A				
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		GOVERNING DIRECTIVES: AFM 66-21 MANO 1 66-3							
		ALL PERSONNEL INVOLVED IN THE WORK PROCEDURES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED TO PREVENT RUST BETWEEN DISPATCH AND REPAIR STATIONS.							
		WARNING MANY OF THE FOLLOWING PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE TRAINING AND PROTECTIVE EQUIPMENT MUST BE AVAILABLE TO PRECLUDE INJURIES							
		*REPAIR INSTRUCTIONS ARE LOCATED IN COLUMN 16 IS EQUIVALENT TO REPAIR STAMP.							
	001	4694034-101A							
	010	*MA-01-001 -----ROUTED COMPONENTS----- NEW/SERVICEABLE REWORK NO REWORK (CONTINUED)					001 MNRPP 002 01 003 MUG6		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21069N			
		B		D					

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER		12. OPTIONAL					
13. SERIAL NUMBER		14. NOUN BALL SCREW ASSEMBLY							
15. DISPATCH STATION	16. PERFORM RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		BALLSCREW 21065N BALL NUT							
		21065N DOB STOP 21067N HEX PIN 21068N							
	010	INSIDE BALL NUT AND BALLSCREW ARE A MATCHED SET						001 MNRGP 002 01 003 PA003	
	001	FOR ASSEMBLY INSPECTION INSPECT ALL COMPONENTS FOR GENERAL CONDITION REPLACE 100% AT EACH OVERHAUL. REPLACEMENT BALLS MUST HAVE A DIAMETER EQUAL TO OR GREATER THAN THE DIAMETER OF BALLS REMOVED AT DISASSEMBLY.						001 MNRGP 002 01 003 LA02	
	002	INSTALL "O" RINGS IN BORE AND INSTALL A NEW "O" RING ON THE SCRAPER WITH THE "O" RING GROOVE. INSTALL 4 EA SCRAPER DRIVE PINS IN BORE OF BALLNUT						001 MNRGP 002 01 003 LA02 004 PA0003	
	003	ASSEMBLE - NOTE: BALLS MUST BE EQUAL TO OR GREATER THAN BALLS REMOVED AT DISASSEMBLY - ALSO, BALLS MUST BE (CONTINUED)						001 MNRGP 002 01 003 LA02 004 PA0003	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21069N			
		B		D					



2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN BALL SCREW ASSEMBLY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		THE SAME SIZE. (DO NOT MIX SIZES) AND REPLACED 100%							
	005 *PRELU*	INSTALL SELECTED BALLS IN OUTER BORE HOLES ONE CIRCUIT AT A TIME. BY DROPPING IN SEVERAL BALLS AT A TIME AND ALIGHT AS THE SCREW ROTATE					001 MNPDP 002 01 003 LA02 004 PA0003		
		HOLDING NOT NECESSARY TO MAKE ROOM FOR MORE BALLS. ***** EACH OF THE TWO OUTER CIRCUITS OF 2 2/3 TURNS HOLD FROM 65 TO 57 BALLS. THE CENTER CIRCUIT OF 3-2/3 FULL 74 TO 76 BALLS							
	000 *PRELU*	WHEN CIRCUIT IS FULL INSTALL REMAINDER OF BALLS IN RETURN TUBES. FILL BOTH ENDS WITH GREASE TO KEEP BALLS FROM FALLING OUT.					001 MNPDP 002 01 003 LA02 004 PA0003		
		OF THE NUT.							
	001 *PRELU*	SELECT SOME TUBES IN THE TUBE HOLES OF FILLED CIRCUITS AND PRESS ON THE GENTLY TO SEAL. ONE OF TUBES IN BOTTOM OF TUBE HOLES IS TO FALL OUT.					001 MNPDP 002 01 003 LA02 004 PA0003		
		BALL IS PLACED WITH BALL.							
	050 *PRELU*	LOAD THE OUTER BORE OF THE CENTER CIRCUIT AND FILL THE LONG TUBE AND GENTLY PRESS INTO BALLNUT. REMOVE TAP AND HEXNUTS AND POSITION CLAMP OVER TUBES AND SECURE HEXNUTS.					001 MNPDP 002 01 003 LA02 004 PA0003		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21069N			
		B		D					

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA		9. ITEM SERIAL NO.	

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN FULL SCREW ASSY.	

15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
	005	USING A DIAL INDICATOR, CHECK BACK LASH APPLY AN AXIAL FORCE OF APPROX 50 LBS. SET DIAL INDICATOR ON FACE OF BALLNUT AND ZERO THE SUM OF READING MUST NOT EXCEED 0.040		001 MNPUP 002 Q1 003 LA02 004 PA0003	
	006	SAFETY WIRE THE HEXNUTS SECURING THE DEFLECTOR YOKES. APPLY SEALER AROUND BALL RETURN TUBES WITH PR-1402 AX OR EQUIVALENT AND ALLOW TO CURE 24 HOURS.		001 MNPUP 002 Q1 003 LA02 004 PA0003	
	007	INSTALL A NEW YO BEYCEE 22X AND FILL BALLNUT WITH GREASE (81212) UNTIL A SMALL AMOUNT COMES OUT THE BOTTOM OF BALLNUT.		001 MNPUP 002 Q1 003 LA02 004 PA0003	
	008	FUNCTIONAL TEST: ROTATE BALLNUT BY HAND THROUGH ONE FULL STROKE IN BOTH DIRECTIONS. THE UNIT SHOULD OPERATE SMOOTHLY WITHOUT RACKLS OR OTHERS PLAYS OF FILE.		001 MNPUP 002 Q1 003 LA02 004 PA0003	
	009	APPLY A THIN COAT OF EMERALD FLUOR-BIODE TO ENTIRE LENGTH OF SCREW. APPLY A COAT OF EMERALD AMS - 3136 NO 310 OR EQUIVALENT TO THE TOP 7.5 INS OF SCREW.		001 MNPUP 002 Q1 003 LA02 004 PA0003	
	010	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY ALL PRECEDING OPERATIONS THIS 958.		001 MNPUP 002 Q1 003 LA02	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/EN
DISPATCH	FUNCTIONAL CODE	A	C	21069N
		B	D	

PREVIOUS EDITION WILL BE USED

CBA from Larry Lawson

1744 HRS/YR for COST SAVINGS.

145 HRS/MONTH for COST SAVINGS.





## DATE

PAGE\_\_OF\_\_PAGES

2084

484

U.S. GOVERNMENT PRINTING OFFICE: 1969-0-687-169

## DATE

PAGE\_\_OF\_\_PAGES

PREVIOUS EDITION WILL BE USED



## 11 DATE

**PAGE\_\_OF\_\_PAGES**

PREVIOUS EDITION WILL BE USED

## 11 DATE

**PAGE\_\_OF\_\_PAGES**

7. PART NUMBER	8. TECH DATA M1910P	9. ITEM SERIAL NO.
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18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19.	20.
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21. FINAL DESTINATION/PRECAUTIONS/COORDINATION/INITIALS/RECEIVED SIGNATURE/DATE	22. DOCUMENT/BN
DISPATCH FUNCTIONAL CODE DECLASSIFIED INJURIES. (CONTINUED)	
	21040N 181

## 11 DATE

PAGE\_\_OF\_\_PAGES

PREVIOUS EDITION WILL BE USED

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## 11 DATE

**PAGE\_\_OF\_\_PAGES**

2. JOB ORDER NO	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
11104091			080491	2 3

7. PART NUMBER	8. TECH DATA	9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
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13. SERIAL NUMBER	14. NOUN
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15. DISPATCH STATION	16. PERF RCC/OP NO	17.  WORK TO BE ACCOMPLISHED	18.  MECHANIC	19.  "P"	20.  "Q"
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	END PRODUCT VISUAL INSPECTION	011 PMS
	WATER TREAT	012 OI
		013 PMS


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21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE	23. DOCUMENT/SN
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	cost			

				21040N	48
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# WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO 21041N	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
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7. PART NUMBER	8. TECH DATA MND 32	9. ITEM SERIAL NO.
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10. MODEL-DESIGN-SERIES	11. STOCK NUMBER 40-1-132 40-1-132	12. OPTIONAL
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13. SERIAL NUMBER	14. NOUN	17575A 6
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15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
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		17576A*			8
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		ALL PERSONNEL EMPLOYED IN THE FACILITY ARE REQUIRED TO BE FAMILIAR WITH ALL FIRST AID PROCEDURES AND TO BE TRAINED IN THE USE OF FIRST AID EQUIPMENT.			
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		ALL PERSONNEL EMPLOYED IN THE FACILITY ARE REQUIRED TO BE FAMILIAR WITH ALL FIRST AID PROCEDURES AND TO BE TRAINED IN THE USE OF FIRST AID EQUIPMENT.			
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		ALL PERSONNEL EMPLOYED IN THE FACILITY ARE REQUIRED TO BE FAMILIAR WITH ALL FIRST AID PROCEDURES AND TO BE TRAINED IN THE USE OF FIRST AID EQUIPMENT.			
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		ALL PERSONNEL EMPLOYED IN THE FACILITY ARE REQUIRED TO BE FAMILIAR WITH ALL FIRST AID PROCEDURES AND TO BE TRAINED IN THE USE OF FIRST AID EQUIPMENT.			
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--	--	---	--	--	--

		ALL PERSONNEL EMPLOYED IN THE FACILITY ARE REQUIRED TO BE FAMILIAR WITH ALL FIRST AID PROCEDURES AND TO BE TRAINED IN THE USE OF FIRST AID EQUIPMENT.			
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21. FINAL DESTINATION	22. PRECAUTIONS	23. DOCUMENT/SN
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DISPATCH	FUNCTIONAL CODE	21041N
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U.S. GOVERNMENT PRINTING OFFICE: 1969-548-129

**11 DATE**

PAGE 01 PAGES

21041N

440

21043N

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## WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCT/REC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA 4S-1-182 4S1-93-3 AND SUPPLEMENTS			9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES		11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER		14. PQUOTON STOP TUBE							
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
482408-1018	1620001299168	17575A 17577A 17578A 17687A							
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FPI IAW MIL-STD-6866 SHOTPEEN IAW MIL-S-13165 ANODIZE IAW MIL-A-8625 ALODINE IAW MIL-C-5541 COST: \$1519.25 *****MAT'L: ALUMINUM 7075-T73*****							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLC FORM 958. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND (CONTINUED)							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21043N
		B	D	

491

## WORK CONTROL DOCUMENT (MEDS)

1. DATE

PAGE

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED			
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.			
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL					
13. SERIAL NUMBER			14. PISTON STOP TUBE								
18. DISPATCH STATION		16. PERF RCC/OP NO.		17. PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.  *REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.			19. MECHANIC		20. "P" "G"		
		001		4612409-101B							
34C5		005		DISASSEMBLE *C/P MOVE			001 MNP GP				
		*REQD*					002 01				
34D		006		DEGREASE ONLY *C/P MOVE			003 SD03				
		*REQD*					001 MNP GW				
							002 02				
				*C/P MOVE			003 DG02				
							001 MNP NA				
		*REQD*					002 05				
34E		020		E AND I INSPECT			003 ZY05				
		*REQD*					001 MNP GW				
							002 04				
34E		030		UPPER END O.D. 8.680 MIN *C/P MOVE NICK AND BURR IAW FIG 5-38			003 EI01				
				T.O. 451-93-3 *C/P MOVE			001 MNP GW				
							002 04				
26		045		STRIP ANODIZE *C/P MOVE			003 EI01				
							001 MNP RC				
				*C/P MOVE			002 03				
							003 AM04				
				*C/P MOVE			001 MNP NA				
				***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* (CONTINUED)			002 08				
							003 ZA02				
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN							
DISPATCH		FUNCTIONAL CODE		A		C		21043N			
				B		D					



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DATE 89035

3 3

## WORK CONTROL DOCUMENT (MEDS)

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER			8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. PISTON STOP TUBE						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. HERE, TAKE WORK PRODUCTION COUNT *****				18. MECHANIC	19. "P"	20. "Q"	
26	060	SHOT PEEN REWORKED AREAS .008-.012 A *C/P MOVE					001 MNPRC		
26	070	ANODIZE IAW MIL-A-8625 TYPE II *C/P MOVE					002 01 003 SF01		
26	075	ALODINE *C/P MOVE					002 03 003 AG03		
69	079	MACHINE PIN IAW DWG 4G19051 *C/P MOVE					001 MNPRA		
69	080	INSTALL PIN IAW DWG 4G19051 *C/P MOVE					002 02 003 LB02		
34 CS	090	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958					001 MNPGR		
34 CS	100	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					002 01 003 ML06		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21043N			
		B		D					

# WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED.	6. DATE COMPLETED
		451-93-3		
7. PART NUMBER	8. TECH DATA		9. ITEM SERIAL NO.	
	451-93-3			

C-5A MLG

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN	

17575A

15. DISPATCH STATION	16. PERF RCC/OP	17. NSN C/N	18. MECHANIC	19. 6	20. 7
	1004	1620003			
		17576A 17577A 17578A		8	
		GOVERNING DIRECTIVES: AFMOR 24-51 HANOI 48-4			
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND ALL SUPPLEMENTS REFERENCED. THE APPLICABLE DOCUMENTS AND SUPPLEMENTS ARE ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (OIL, GREASE, ETC.) BEFORE MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		REPAIRS SHALL BE MADE IN THE PRESENCE OF THE QUALIFIED REPAIR PERSONNEL. PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & OPERATIONS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. SPECIALIST TRAINING PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		*REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	4G11416-101B			
	005A	Disassembly			

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. 2 DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	
		B	D	

1. Wheels operation - okay
2. Brakes operation - okay
3. MLG struts - loading up this afternoon 3 Aug. 89.
4. Brakes operation files - look good
5. Wheels operation files - look good.
6. WRITE Para on Surge
7. Write Para on Non. Process Improvement OPPORTUNITIES.

## 21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		21020N CROSSWIND APEX BOLT							
		21017N PISTON SUB ASSY							
		21028N SPLINED ORIFICE TUBE							
		21007N RESTRICTOR							
		21046N SPLINED SLIDE RING							
		21055N PACKING NUT							
		21062N LOWER BEARING							
		21040N UPPER BEARING							
		LOCK RING ASSY							
		21030N COLLAR LOCK INSERT							
		21035N COLLAR LOCK COLLAR							
		21026N THRUST BEARING							
		21041N ROTATION COLLAR							
		21036N SPLINED TUB NUT							
		21060N ROLL PIN							
		21041N ROLL PIN ROUND NUT							
		21038N HEADLESS APEX PIN							
		21011N FLUID TRANSFER HOUSING							
		21048N STEPPED SWIVEL FTG							
		21091N (INT) SWIVEL FTG							

(CONTINUED)

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	21058N
		B	D	

## 21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 4 OF 4 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY						
18. DISPATCH STATION	19. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		21093N LARGE SWIVEL FTG 21093N GAUGE (2)							
		21059N STRUT HEADER SHEET 000097							
3405	015 *REQD*	PLACE YOKE UPSIDE DOWN IN YOKE FIXTURE AND INSTALL 3" RING AND THRUST WASHER						001 MNP GP 002 01 003 CC22	
3405	020 *REQD*	ASSEMBLE BALLSCREWS, SPROCKETS, THRUST BEARINGS, RADIAL BEARINGS AND RETAINERS INTO THE BALLSCREW BORE						001 MNP GP 002 01 003 CC22	
3405	025 *REQD*	PLACE YOKE ASSY IN PREASSY STAND AND INSTALL OUTER CYL AND ELECT INSERT ACCORDING TO PROPER CONFIGURATION						001 MNP GP 002 01 003 PA04	
3405	030 *REQD*	PLACE POSITIONING COLLAR ON OUTER CYL AND INSTALL SHAFTS, BRACKETS, ELECT HARNESS ASSY MANIFOLDS AND HYD TUBING IN SEQUENCE						001 MNP GP 002 01 003 PA04	
3405	035 *REQD*	INSTALL HYD FLEX LINES, CROSSWIND SYSTEM, VALVES AND LOCK CYLS, INSTALL KNEELING SYSTEM AND CHAIN COVER						001 MNP GP 002 01 003 PA04	
3405	040 *REQD*	INSTALL ROTATION CYL. CONNECT ALL ELECT LEADS AND COMPLETE ELECT HARNESS ASSY.						001 MNP GP 002 01 003 PA04	
3405	045 *REQD*	TORQUE ALL HYD LINES, FITTINGS AND TUBING IAW TORQUE VALVE TABLE ON PAGE 9-4 IN T.O. 451-93-3						001 MNP GP 002 01 003 PA04	
3405	050 *REQD*	MOVE STRUT INTO TEST STAND AND SECURE IT. CLEAN I.D. OF OUTER CYL TO REMOVE ANY AND ALL FOREIGN (CONTINUED)						001 MNP GP 002 01 003 705	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
ATCH	FUNCTIONAL CODE	A		C		21058N			
		B		D					

## 21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 5 OF 6

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		MATERIAL-- OK TO ASSEMBLE OR CLOSE							
3405	055 *REQD*	ASSEMBLE ALL ITEMS REQUIRED TO BUILD UP THE O.D. OF THE PISTON SUB ASSY. INSTALL SPLIED TUBE ASSY.					001 MNP GP 002 01 003 FA05		
3405	060 *REQD*	INSURE THAT ALL ALIGNING MARKS ON ALL ITEMS ARE PROPERLY ALIGNED. INSURE THAT ALL TABS ARE LOCKED PROPERLY.					001 MNP GP 002 01 003 FA05		
3405	065 *REQD*	GREASE I.D. OF OUTER AND UPPER & LOWER BEARINGS AND INSTALL PISTON SUBASSY IN OUTER CYL AND LOCK IN PLACE.					001 MNP GP 002 01 003 FA05		
3405	070 *REQD*	INSTALL ALL ITEMS USE TO BUILD UP THE TOP END. FILL UPPER CHAMBER WITH 13+/- GALS OF HYD FLUID. STROKE STRUT TO REMOVE TRAPPED AIR.					001 MNP GP 002 01 003 FA05		
3405	075 *REQD*	CHARGE STRUT WITH 2500 +/- PSI IN LOWER CHAMBER AND 475 +/- PSI IN UPPER CHAMBER ALL PRESSURE TO STABILIZE APPROX 30 MIN.					001 MNP GP 002 01 003 FA05		
3405	080 *REQD*	USING A TOTALIZING VESSEL AT LOWER CHAMBER ALLOWABLE LEAKAGE IS 100 CC IN ONE HR WITH A PRESSURE GAUGE. THERE SHALL BE NO LOSS/GAIN FROM UPPER CHAMBER FOR 1 HR.					001 MNP GP 002 01 003 FA05		
3405	085 *REQD*	CYCLE STRUT 25 TIMES AT 300 PSI TO CHARGE ALL HYD LINES AND CYLS PERFORM LOW PRESSURE ROTATION TEST AND RECORD PRESSURES: NORMAL ROTATION 0-90 DEGREES NORMAL ROTATION 90-0 DEGREES (CONTINUED)					001 MNP GP 002 01 003 FA05		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21058N			
		B		D					

## 21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA 4S1-93-3 & SUPPLEMENTS				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES C5A MLG			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
P/N		NSN C/N							
4G11020-107A		1620010054191 17575A							
4G11020-105A		1620010054192 17576A							
4G11020-101A		1620010054193 17577A							
4G11020-103A		1620010054194 17578A							
		GOVERNING DIRECTIVES: AFLDR 66-51 MANOI 66-3							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLIC- ABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.							
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		*****M A R N I N G***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		*REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP							
	001	4G11020-107A 4G11020-105A 4G11020-101A (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21058N			
		B		D					

## 21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 890434

2  
PAGE OF PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN STRUT ASSY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		4G11020-103A							
3405	010	* * * * * M A T C H - U P * * * * * NEW/SERVICEABLE REWORKED NO REWORK YOKE ASSY 21015N BALLSCREW ASSY (2) 21069N BALLSCREW SPROCKET 21037N KNEELING DRIVE GEAR ASSY 21045N UPPER SIDE BRACE ARM 21009N UPPER SIDE BRACE SHAFT 21005N LOWER SIDE BRACE ARM 21013N LOWER SIDE BRACE SHAFT 21006N SIDE BRACE APEX BOLT 21025N RETRACT ARM ASSY 21018N TRUNNION PIN 21019N TRUNNION CROSS BOLT (2) 21024N OUTER CYL ASSY 21001N ANCHOR SHAFT (2) 21034N BALLSCREW CROSS PIN (2) 21051N POSITIONING COLLAR 21016N ANTI ROTATION BOLT (2)						001 MNP GP 002 01 003 MU06	
		(CONTINUED)							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN	
ATCH	FUNCTIONAL CODE	A	C	21058N	
		B	D		



## 21058N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89043

PAGE 6 OF 6 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED.		6. DATE COMPLETED		
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL				
13. SERIAL NUMBER			14. NOUN STRUT ASSY							
15. DISPATCH STATION		16. PERP RCC/OP NO.		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P" "Q"	
				LOCKED AT _____ EM9 ROTATION 90-0 DEGREES						
				LOCKED AT _____						
34C5		090 *REQD*		CYCLE CROSSWIND CYLS 25 TIMES AT 3000 PSI AND CHECK ALL HYD LINES AND TUBES THERE SHALL BE NO LEAKAGE AT ANY CONNECTION					001 MNP GP 002 01 003 FA05	
34C5		095 *REQD*		CHECK AND SET THE INTER LOCK SYSTEM SET AND CHECK BALLSCREW RIGGING AND SAFETY WIRE DOG STOPS AND HEX NUTS.					001 MNP GP 002 01 003 FA05	
34C5		100 *REQD*		INSTALL FLUID TRANSFER HOUSING, IN FLIGHT BRAKE SYSTEM, ROLL PIN ASSY, SIDE BRACES, RETRACT ARM, AND TRUNNION PIN.					001 MNP GP 002 01 003 FA05	
34C5		105 *REQD*		CLEAN OFF ALL EXCESS GREASE, OIL AND DIRT FROM ENTIRE STRUT. DECAL AND TOUCH UP PAINT A REQUIRED.					001 MNP GP 002 01 003 FA05	
34C5		110 *REQD*		INSPECT STRUT OVER ALL FOR RUBBING AND CHAFING HYD LINES. WRAP AND PROTECT ELECT CANNON PLUGS.					001 MNP GP 002 01 003 FA05	
34C5		115 *REQD*		FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 95B					001 MNP GP 002 01 003 FA05	
34C5		120 *REQD*		FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					001 MNP GP 002 01 003 FA05	
21. FINAL DESTINATION				22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN		
ATCH		FUNCTIONAL CODE		A		C		21058N		
				B		D				

## 21035N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89035

PAGE 4 OF 4 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
7 PART NUMBER	8 TECH DATA		9 ITEM SERIAL NO.	

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN COLLAR LOCK INSERT	

15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED	18 MECHANIC	19 P	20 Q
26	078	PRIOR TO CAD/IVD, GRIT BLAST ALL AREAS TO BE CAD/IVD PLATED *C/P MOVE		M	
26	080	CADMIUM PLATE TYPE II CLASS II DO NOT PLATE ACME THREADS DATE OUT _____ TIME OUT _____ *C/P MOVE		M	
26B	090	BAKE 20 HRS AT 350-400F WITHIN 4 HRS OF CAD PLATE DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE			
26	100	IRIDITE-CHROMATE CONVERSION COATING *C/P MOVE		M	
		*C/P MOVE		K	
		*** NOTE *** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT *	M		
		*****			
26	115	IVD PLATE (INITIATED BY PLATING) *C/P MOVE		M	
26	120	ALODINE IVD PLATED AREAS. (INITIATED BY PLATING) *C/P MOVE		M	
	130	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958 *REQI*		M	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	21035N
		B	D	

582

U.S. GOVERNMENT PRINTING OFFICE: 1980-648-183

## 21035N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89035

PAGE 5 OF 5 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN COLLAR LOCK INSERT						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. P	20. Q	
	140 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE					M		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21035N			
		B		D					

## 21036N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE \_\_\_ OF \_\_\_ PAGES

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GP		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA 45-1-182 451-93-3 AND SUPPLEMENTS				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES CSA MLG			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN ROTATION COLLAR (MLG)						
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
P/N 4G13565-101B		NSN C/N 1620004884553 17575A <del>17578A</del> 17577A 17578A							
		GOVERNING DIRECTIVES: AFLCR 66-51 MANDI 66-3 FMPI IAW MIL-STD-1949 P/O N01561							
		TEMPER ETCH IAW MIL-STD-867 SHOT PEEN IAW MIL-S-13165 CAD PLATE IAW MIL-STD-870 PHOSPHATE TREATMENT IAW DOD-P-16232 P/O N73061							
		BAKE TYPE M CLASS 4 IAW 45-1-182 MAOI 74-12							
		MAT'L: 300M 280,000-200,000 KSI COST: \$1016.61 ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED IN BLOCK 8 OF THIS AFLO FORM 959. THE APPLI- CABEL T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING MANY OF THE FOLLOWING REPAIR (CONTINUED)							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21036N			
		P		D					

## 21036N WORK CONTROL DOCUMENT (MEDS)

1 DATE

89035

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO.	
10 MODEL-DESIGN-SERIES		11 STOCK NUMBER		12 OPTIONAL					
13 SERIAL NUMBER		14 NOUN		ROTATION COLLAR (MLG)					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19	20	
		PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURES.							
		*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	4G13545-101B							
	005	DISASSEMBLE *C/P MOVE					M		
	*REQD*								
		DEGREASE ONLY *C/P MOVE					M		
	*REQD*								
		BLAST CLEAN ONLY *C/P MOVE					M		
	*REQD*								
		BAKE 4 HRS AT 350-400F							
	*REQD*	DATE IN _____ TIME IN _____							
		DATE OUT _____ TIME OUT _____							
		*C/P MOVE							
		*C/P MOVE							
	*REQD*					M	K		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21036N			
		B		D					

## 21036N WORK CONTROL DOCUMENT (MEDS)

1 DATE 89035

PAGE 1 OF 1 PAGES

2. JOB ORDER NO		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED				
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.				
10. MODEL-DESIGN-SERIES				11. STOCK NUMBER		12. OPTIONAL						
13. SERIAL NUMBER				14. NOUN ROTATION COLLAR (MLG)								
15. DISPATCH STATION		16. PERF RCC/OP NO.		17. WORK TO BE ACCOMPLISHED			18. MECHANIC		19. "P"		20. "Q"	
				E & I IAW 4S1-93-3 FIG 5-28 REMOVE MINOR NICKS AND DEFECTS. *C/P MOVE								
26		025		VAPOR DEGREASE *C/P MOVE								
26		030		STRIP CAD *C/P MOVE								
26		035		STRIP RUST *C/P MOVE								
				TIME OUT _____ DATE OUT _____ *C/P MOVE			M		K			
				***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****								
26B		050		BAKE 4 HRS AT 350-400F WITHIN 8 HRS OF TEMPER ETCH DATE IN _____ TIME IN _____								
				DATE OUT _____ TIME OUT _____ *C/P MOVE								
				*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* HERE, TAKE PRODUCTION COUNT * *****			M		K			
				*****								
21. FINAL DESTINATION				22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN				
DISPATCH		FUNCTIONAL CODE		A		C		21036N				
				B		D						

## 21036N WORK CONTROL DOCUMENT (MEDS)

DATE 89035

PAGE 4 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA				9 ITEM SERIAL NO		
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ROTATION COLLAR (MLG)						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
26	063	VAPOR DEGREASE *C/P MOVE							
26	065	GRIT BLAST SPLINES TO REMOVE CORROSION *C/P MOVE					M		
26	070	SHOT PEEN ALL NICK & BURRED AREAS INTENSITY OF .008/.012 A2 NOTE: DO NOT PEEN THREADS *C/P MOVE					M		
26	080	SHOT PEEN REWORKED THREADS INTENSITY OF .005/.010 A2 SHOT SIZE 110 *C/P MOVE					M		
26	085	PRIOR TO CAD PLATE, GRIT BLAST ALL AREAS TO BE CAD PLATED. *C/P MOVE					M		
26	090	CADMIUM PLATE TYPE II CLASS II (EXCEPT EXTERNAL SPLINE) 2.3 SQ FT AT 115-161 AMPS TIME OUT DATE OUT *C/P MOVE					M		
26B	100	BAKE 24 HRS AT 350-400F WITHIN 4 HRS OF CAD PLATE DATE IN TIME IN DATE OUT TIME OUT *C/P MOVE							
		*C/P MOVE ***** NOTE ***** IF LAST NDI OPERATION IS COMPLETED* (CONTINUED)				M	K		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		21036N			
		B		D					

## 21036N WORK CONTROL DOCUMENT (MEDS)

DATE 89035

PAGE 5 OF 5 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER			8 TECH DATA			9 ITEM SERIAL NO			
10 MODEL-DESIGN-SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN ROTATION COLLAR (MLG)						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19 P	20 Q	
		HERE, TAKE PRODUCTION COUNT *****							
26	113	VAPOR DEGREASE *C/P MOVE							
26	117	PRIOR TO PHOSPHATE, GRIT BLAST ALL AREAS TO BE PHOSPHATE COATED *C/P MOVE					M		
26	120	PHOSPHATE EXTERNAL SPLINE *C/P MOVE					M		
26B	130	BAKE 8 HRS AT 210-225F 1AW DATE IN _____ TIME IN _____ DATE OUT _____ TIME OUT _____ *C/P MOVE							
26	140	IRIDITE-CHROMATE CONVERSION COATING *C/P MOVE					M		
	150	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY *REQD* OF ALL PRECEDING OPERATIONS THIS 958					M		
	160	FINAL PRODUCT VISUAL INSPECTION *REQD* *C/P MOVE					M		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		21036N			
		B		D					



# WORK CONTROL DOCUMENT (MEDS)

1. DATE

PAGE 1 OF 1 PAGES

2. JOB ORDER NO 21037N	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED 19035	6. DATE COMPLETED 1
7. PART NUMBER		8. TECH DATA MNPCE		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER 45-1-122 451-4-10 AND SUPPLEMENT 1	12. OPTIONAL
13. SERIAL NUMBER 12345	14. NOUN	

17575A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. P	20.
		NSN D/N			6
		17576A 17577A 17578A			7
					8
		UNIT COST: \$100.15			
		COVERING LINES (VES): 4000 8-51 CONVI 8-51			
		DEL PLATE 1AW MIL-STD-883C BASE 1AW MIL-STD-883C			
		SHOT PEEN 1AW MIL-STD-883C OAR PLATE 1AW MIL-STD-883C BASE 1AW MIL-STD-883C			
		ALODINE 1AW MIL-STD-883C MATEL: 4230 (250,000-240,000 KSI)			
		ALL PERSONNEL SHALL BE TRAINED IN THE PROPER USE OF THE TOOLING AND EQUIPMENT HAVE BEEN TRAINED IN THE PROPER USE OF THE TOOLING AND EQUIPMENT			
		PRACTICES AND PROCEDURES SHALL BE USED AS THE BASIC TECHNICAL REQUIREMENTS AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			

## WARNING

21. FINAL DESTINATION DISPATCH	22. THE COORDINATING OFFICE FUNCTIONAL CODE	23. SIGNATURE/DATE	24. DOCUMENT/SN
			21037N

## DATE

PAGE\_\_OF\_\_PAGES

21037N

## DATE

PAGE\_\_OF\_\_PAGES

PREVIOUS EDITION WILL BE USED

# WORK CONTROL DOCUMENT (MEDS)

1 DATE

PAGE 4 OF 4 PAGES

2. JOB ORDER NO 21037N		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED 8/10/85		6. DATE COMPLETED 4	
7. NUMBER				8. TECH DATA				9. ITEM SERIAL NO	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN						
15. DISPATCH STATION	16. PERF RCC OP NO	17. WORK TO BE ACCOMPLISHED					18. MECHANIC	19. "P"	20. "O"
		1. WHITE-CHROME COAT LAYERS 10/11/85						001	
		2. COAT						002	
		3. COAT						003	
		4. COAT						004	
		5. COAT						005	
		6. COAT						006	
		7. COAT						007	
		8. COAT						008	
		9. COAT						009	
		10. COAT						010	
		11. COAT						011	
		12. COAT						012	
		13. COAT						013	
		14. COAT						014	
		15. COAT						015	
		16. COAT						016	
		17. COAT						017	
		18. COAT						018	
		19. COAT						019	
		20. COAT						020	
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE					23. DOCUMENT		
DISPATCH	FUNCTIONAL CODE	A							
		B							
		C							
		D							
							21037N		